SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

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ATA SYSTEM: 57

TITLE: WINGS - GENERAL - ONE TIME INSPECTION OF TAPERLOK BOLT AT WING TO FUSELAGE JUNCTION.

MODIFICATION No.: None

This page transmits Revision No.03 of Service Bulletin No.A320-57-1131

ADDITIONAL WORK

****CONF ALL**

ADDITIONAL WORK is required by this revision for aircraft modified by the original issue and revision No. 01 of this Service Bulletin.

The ADDITIONAL WORK consists in inspecting new fasteners located in the center and outer wing box in the Rib1 area.

REASON

Revision No. 03 issued to correct the KIT 571131A06 Revision Number (typing error), KIT 571131A06R04 instead of KIT 571131A06R03.

CHANGES

The main changes of this revision are:

- KIT 571131A06 revision number updated (KIT 571131A06R04 instead of KIT 571131A06R03),
- minor changes applied due to format changes introduced by new authorities' rules.

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Supplementary Kit 571131A06S01	PART MATERIAL SET UPDATED	R
Supplementary Kit 571131A07S01	PART MATERIAL SET UPDATED	R
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Subtask 571131-910-001-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-910-001-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-941-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED	R
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Subtask 571131-010-002-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-832-006-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-007-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-006-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-007-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
TASK 571131- 833-802-001-REPAIR	TASK SOLUTION UPDATED CAUTION UPDATED NOTE UPDATED	R
Subtask 571131-910-002-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-910-002-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-833-017-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R

Subtask 571131-833-018-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-019-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-020-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
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Subtask 571131-833-019-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-020-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-710-002-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-710-002-001	SUBTASK SOLUTION UPDATED	R
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Subtask 571131-410-004-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-942-002-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-410-003-001	SUBTASK SOLUTION UPDATED	R
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TASK 571131- 832-803-001-INSPECTION ADDITIONAL WORK	TASK SOLUTION UPDATED CAUTION UPDATED NOTE UPDATED	R
Subtask 571131-910-003-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-910-003-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R

Subtask 571131-941-002-001	SUBTASK SOLUTION UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 571131-941-002-001	SUBTASK SOLUTION UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 571131-832-008-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-009-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-008-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
Subtask 571131-832-009-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED REFERENCES UPDATED	R
TASK 571131- 833-804-001-REPAIR ADDITIONAL WORK	TASK SOLUTION UPDATED CAUTION UPDATED NOTE UPDATED	R
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Subtask 571131-910-004-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 571131-833-021-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-022-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-023-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R

Subtask 571131-833-024-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-021-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-022-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-023-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-833-024-002	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 571131-710-003-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-710-003-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-410-005-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-410-006-001	SUBTASK SOLUTION UPDATED	R
Subtask 571131-942-003-001	SUBTASK SOLUTION UPDATED	R
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Fig. A-FRAAA	FIGURE SOLUTION ADDED	N
Fig. A-FRAAA Sheet 01	SHEET ADDED	N
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Appendix 02 - Elapsed Time Assumption		
APPENDIX CONTENT	APPENDIX CONTENT UPDATED	R
Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK)		
APPENDIX CONTENT	APPENDIX CONTENT UPDATED	R

FILLING INSTRUCTIONS

This Service Bulletin has been generated electronically and is reissued as a complete document. Replace the complete document.

Put this Revision Transmittal Sheet in front of the Service Bulletin.

HISTORY OF PREVIOUS REVISIONS

This Service Bulletin has been validated on A320 aircraft MSN 1387.

Revision No. 01 issued to include minor improvements after validation :

to add the removal/installation procedure of the fuel pump suction valve, AMM 28-21-42,

to add the removal/installation procedure of the fuel pump strainer covers, AMM 28-21-54,

to modify the flow chart,

to update tooling needed,

to update the configuration effectivity.

This Service Bulletin has been validated on A320 aircraft MSN 1387.

Revision No. 02 issued to update the detailed inspection area of the center and outer wing box in the Rib1 and modify the Accomplishment Timescale.

REVISION SEQUENCE

ORIGINAL: Nov 21/06

REVISION No. : 01 - Feb 15/11

REVISION No. : 02 - Nov 25/13

REVISION No. : 03 - Jun 29/15

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SERVICE BULLETIN
SUMMARY

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This summary is for information only and is not approved for modification of the aircraft.

ATA SYSTEM: 57

TITLE: WINGS - GENERAL - ONE TIME INSPECTION OF TAPERLOK BOLT AT WING TO FUSELAGE JUNCTION.

****CONF ALL**

MODIFICATIONS

None

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

During installation of the wing to the center wing box in the AIRBUS A320 family Final Assembly Line (FAL), some taperloks used in the wing to fuselage junction at RIB 1, were found to be non-compliant with the specification.

These fasteners have been used on limited number of aircraft.

Fatigue tests on samples and calculations have demonstrated that a loss in pre-tension results in reduction of the fatigue life of the assembly.

AIRBUS decided to check also the condition of the taperloks compliant to the specification used on older aircraft.

At critical locations, the new calculated fatigue life falls below the aircraft Design Service Goal (DSG) of 48,000 Flight Cycles (FC).

Consequently, two Inspection Service Bulletins were launched to perform an internal (Service Bulletin No. A320-57-1129) and an external (Service Bulletin No. A320-57-1130) ultrasonic Inspection on the stiffeners and the lower panels at rib 1, on the center wing box side and the outer wing box side.

This Inspection Service Bulletin consists in carrying out a detailed inspection of fasteners located in center and outer wing box in rib 1 area.

In accordance with the result of the inspection :

- replace the nut by install appropriate washer with a new self locking nut,
- replace the damaged taperlok with a new taperlok at next nominal diameter with self locking nut.

Accomplishment of this Service Bulletin cancels the inspection requirements of inspection Service Bulletin No. A320-57-1129 & No. A320-57-1130 and restore the fatigue potential in the zone to the level initially certified.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	RECOMMENDED (1)	CANCELS INSPECTION SB	YES
POTENTIAL AD	NO	A/C OPERATION AFFECTED	NO
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	NO	VENDOR SB INVOLVED	NO
DE-FUELLING/VENTILATION	YES		

NOTE (1): Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

NOTE: This Service Bulletin has been validated at original issue on A320 aircraft with Manufacturer Serial Number (MSN) 1387.

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 571131A06R04	2	6,460.00	Bolt, nut, washer
Supplementary kit 571131A06S01	2	3,780.00	Bolt, nut, washer
Kit tool 571131T01R02	1	1,000.00	Gage
Kit tool 571131T02R00	1	1,364.00	Test
TOTAL		**12,604.00**	
Component COMPA01	1	See SB	Screw, nut , washer
Component COMPA03	1	See SB	Screw, nut , washer

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 571131A07R03	2	6,320.00	
Supplementary kit 571131A07S01	2	3,460.00	Bolt, nut, washer
Kit tool 571131T01R02	1	1,000.00	Gage
Kit tool 571131T02R00	1	1,364.00	Test
TOTAL		**12,144.00**	
Component COMPA01	1	See SB	Screw, nut , washer

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Component COMPA04	1	See SB	Screw, nut , washer

EFFECTIVITY

****CONF ALL**

This Service Bulletin is applicable to this (these) operator(s) :

AAY ABQ AFR AJD AUA AZA BAW BEL CES CIB DAL EIN FIN
GMR IBS JBU KKK LAN LLP MON SAI SAS SDM SKU SVR TAE
TAM TCW UAL USA VLG VVC

NOTE: This Service Bulletin has been validated on A320 aircraft MSN 1387.

NOTE: Two booklets including photographs taken during the validation of this Service Bulletin are available on AirbusWorld - Maintenance and Engineering - Service Bulletin Information.

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

TFU	57.11.00.006
OEB	None
AOT	None
SIL	None
ISI	None
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None
OTHERS	OIT SE999.0078/04CL

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

****CONF 001**

Task 571131-832-801-001: INSPECTION	
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

Task 571131-833-802-001: REPAIR	
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK	
TOTAL MANHOURS	51.00
ELAPSED TIME (HOURS)	13.50

Task 571131-833-804-001: REPAIR ADDITIONAL WORK	
TOTAL MANHOURS	53.50
ELAPSED TIME (HOURS)	19.00

****CONF 002**

Task 571131-832-801-001: INSPECTION	
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

Task 571131-833-802-001: REPAIR	
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK	
TOTAL MANHOURS	47.00
ELAPSED TIME (HOURS)	12.50

Task 571131-833-804-001: REPAIR ADDITIONAL WORK	
TOTAL MANHOURS	45.50
ELAPSED TIME (HOURS)	17.00

APPENDICES

****CONF ALL**

- Appendix 01 - Weight Variant (WV) correspondence table
- Appendix 02 - Elapsed Time Assumption
- Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK)

**CONF ALL

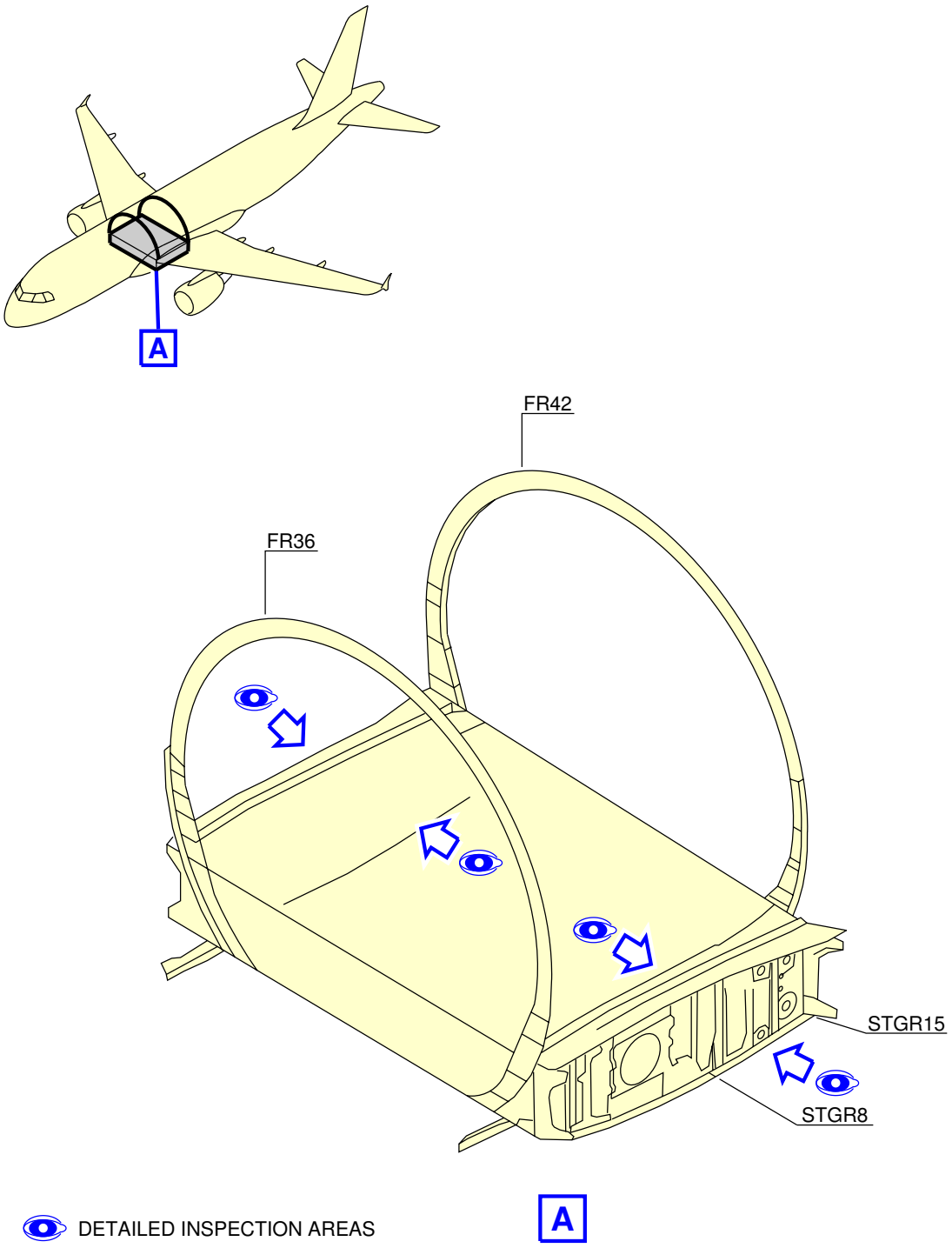

Figure A-FSAAA - Sheet 01

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ATA SYSTEM: 57

TITLE: WINGS - GENERAL - ONE TIME INSPECTION OF TAPERLOK BOLT AT WING TO FUSELAGE JUNCTION.

MODIFICATION No.: None

1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This Service Bulletin is only applicable to aircraft on which modification No. 26503P4809 (REPLACE TAPER-LOCK FASTENERS BY PULL TYPE FASTENERS ON SECTION 21) is embodied.

(1) Models

320-212 320-214 320-232 320-233

(2) Effectivity by MSN

1379 1381 1383 1385 1387 1390 1394 1396 1398 1400 1402 1405 1407 1409 1411
1413 1416 1418-1419 1422 1424 1427 1430 1432 1435 1437 1439 1441 1443 1446
1448 1450 1452 1454 1457 1459 1461 1467 1469-1470 1473 1475 1478 1480 1482
1484 1486 1489 1491 1493 1495 1497 1500 1502 1504 1506 1508-1509 1512 1514
1516 1518 1523 1526 1528 1530 1532-1533 1535 1538 1540 1542 1544

(3) Effectivity by Operator

The Operator/MSN relationship is provided for information only and is correct at the time of issue in accordance with the information available to AIRBUS. Any future changes resulting from transfer of an aircraft from one operator to another will not be reflected in this list unless the Service Bulletin is revised for another reason.

OPERATOR	MSN
AAY	1530 1540
ABQ	1467
AFR	1502
AJD	1422
AUA	1385 1387 1478 1504
AZA	1448 1457 1473 1480 1489
BAW	1418 1424 1482 1509
BEL	1441 1493
CES	1532 1542
CIB	1381 1416 1437
DAL	1535
EIN	1394 1443
FIN	1405 1470 1544
GMR	1407
IBS	1439 1450 1516
JBU	1398 1446 1452 1506 1528
KKK	1390
LAN	1491 1512 1526
LLP	1411
MON	1413
SAI	1497
SAS	1383
SDM	1379
SKU	1400 1523
SVR	1484
TAE	1500
TAM	1459 1486 1518
TCW	1402
UAL	1409 1427 1432 1435 1469 1475 1495 1508 1514 1533 1538
USA	1419
VLG	1396 1430 1461
VVC	1454

(4) Configuration by MSN

MSN	CONFIGURATION
1379 1381 1383 1387 1390 1396 1398 1400 1402 1407 1409 1413 1416 1418 1419 1422 1424 1427 1430 1432 1435 1437 1439 1446 1448 1450 1452 1454 1457 1459 1461 1469 1473 1475 1478 1480 1482 1484 1486 1489 1491 1495 1497 1500 1506 1508 1509 1512 1514 1516 1518 1523 1526 1528 1530 1532 1533 1535 1538 1540 1542	001
1385 1394 1405 1411 1441 1443 1467 1470 1493 1502 1504 1544	002

(5) Configuration definition

**CONF 001
Config. 001 concerns A320-200 aircraft model with a Weight Variant (WV) 000 thru 010 and 013 (Refer to Appendix 01 - Weight Variant (WV) correspondence table).

**CONF 002
Config. 002 concerns A320-200 aircraft model with a Weight Variant (WV) 011, 012, 014, 015 and 016 (Refer to Appendix 01 - Weight Variant (WV) correspondence table).

(6) Material Effectivity

**CONF 001

MATERIAL	QTY PER A/C	SEE NOTES
Kit 571131A06R04	2	
Supplementary kit 571131A06S01	2	
Kit tool 571131T01R02	1	
Kit tool 571131T02R00	1	
Component COMPA01	1	
Component COMPA03	1	
Consumable CMLA01	As required	

**CONF 002

MATERIAL	QTY PER A/C	SEE NOTES
Kit 571131A07R03	2	
Supplementary kit 571131A07S01	2	
Kit tool 571131T01R02	1	
Kit tool 571131T02R00	1	
Component COMPA01	1	
Component COMPA04	1	
Consumable CMLA01	As required	

**CONF ALL

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

During installation of the wing to the center wing box in the AIRBUS A320 family Final Assembly Line (FAL), some taperloks used in the wing to fuselage junction at RIB 1, were found to be non-compliant with the specification.

These fasteners have been used on limited number of aircraft.

Fatigue tests on samples and calculations have demonstrated that a loss in pre-tension results in reduction of the fatigue life of the assembly.

AIRBUS decided to check also the condition of the taperloks compliant to the specification used on older aircraft.

At critical locations, the new calculated fatigue life falls below the aircraft Design Service Goal (DSG) of 48,000 Flight Cycles (FC).

Consequently, two Inspection Service Bulletins were launched to perform an internal (Service Bulletin No. A320-57-1129) and an external (Service Bulletin No. A320-57-1130) ultrasonic Inspection on the stiffeners and the lower panels at rib 1, on the center wing box side and the outer wing box side.

(2) Objective/Action

This Inspection Service Bulletin consists in carrying out a detailed inspection of fasteners located in center and outer wing box in rib 1 area.

In accordance with the result of the inspection :

- replace the nut by install appropriate washer with a new self locking nut,
- replace the damaged taperlok with a new taperlok at next nominal diameter with self locking nut.

(3) Advantages

Accomplishment of this Service Bulletin cancels the inspection requirements of inspection Service Bulletin No. A320-57-1129 & No. A320-57-1130 and restore the fatigue potential in the zone to the level initially certified.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 571131-832-801-001: INSPECTION

(1) LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

(2) RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Task 571131-833-802-001: REPAIR

(1) Replace the Nuts on the LH Side

(2) Replace the Nuts on the RH Side

(3) Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side

(4) Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK

(1) LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

(2) RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Task 571131-833-804-001: REPAIR ADDITIONAL WORK

(1) Replace the Nuts on the LH Side, ADDITIONAL WORK

(2) Replace the Nuts on the RH Side, ADDITIONAL WORK

(3) Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK

(4) Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK

****CONF 002**

Task 571131-832-801-001: INSPECTION

(1) LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

(2) RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Task 571131-833-802-001: REPAIR

(1) Replace the Nuts on the LH Side

(2) Replace the Nuts on the RH Side

(3) Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side

(4) Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK

(1) LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

(2) RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Task 571131-833-804-001: REPAIR ADDITIONAL WORK

(1) Replace the Nuts on the LH Side, ADDITIONAL WORK

(2) Replace the Nuts on the RH Side, ADDITIONAL WORK

(3) Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK

(4) Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK

**CONF ALL

E. COMPLIANCE

(1) Classification

RECOMMENDED: Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin is recommended at the earliest opportunity where manpower and facilities are available.

F. APPROVAL

The technical content of this document is approved under authority of Design Organization Approval No. EASA.21J.031.

If an aircraft listed in the effectivity has a modification or repair embodied that is not of AIRBUS origin, and which affects the content of this Service Bulletin, the operator is responsible for obtaining approval by its airworthiness authority for any adaptation necessary before incorporation of the Service Bulletin.

G. MANPOWER

The manpower estimates given in this Service Bulletin are based on the direct labor cost to do the work. These estimates assume that the work will be done by experienced personnel, and may need to be revised upwards to suit operator's circumstances. The estimates do not include the time to prepare, plan or inspect the work. Manufacture and procurement of parts and tools, drying times for paints, sealants, etc., and general administration work are also not included.

**CONF 001

Task 571131-832-801-001: INSPECTION	
Get Access	17.00
On Aircraft	
LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction	26.00

Task 571131-832-801-001: INSPECTION	
RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction	26.00
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FABAA given in Appendix 02 - Elapsed Time Assumption .

Task 571131-833-802-001: REPAIR	
On Aircraft	
Replace the Nuts on the LH Side	12.00
Replace the Nuts on the RH Side	12.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side	16.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side	16.00
Tests	5.00
Close-Up	14.50
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FACAA given in Appendix 02 - Elapsed Time Assumption .

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK	
Get Access	17.00
On Aircraft	
LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK	17.00
RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK	17.00
TOTAL MANHOURS	51.00
ELAPSED TIME (HOURS)	13.50

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FADAA given in Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK) .

Task 571131-833-804-001: REPAIR ADDITIONAL WORK	
On Aircraft	
Replace the Nuts on the LH Side, ADDITIONAL WORK	7.00
Replace the Nuts on the RH Side, ADDITIONAL WORK	7.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK	10.00

Task 571131-833-804-001: REPAIR ADDITIONAL WORK	
Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK	10.00
Tests	5.00
Close-Up	14.50
TOTAL MANHOURS	53.50
ELAPSED TIME (HOURS)	19.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FAEAA given in Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK) .

**CONF 002

Task 571131-832-801-001: INSPECTION	
Get Access	17.00
On Aircraft	
LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction	26.00
RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction	26.00
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FABAA given in Appendix 02 - Elapsed Time Assumption .

Task 571131-833-802-001: REPAIR	
On Aircraft	
Replace the Nuts on the LH Side	12.00
Replace the Nuts on the RH Side	12.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side	16.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side	16.00
Tests	5.00
Close-Up	14.50
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FACAA given in Appendix 02 - Elapsed Time Assumption .

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK	
Get Access	17.00
On Aircraft	
LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK	15.00

Task 571131-832-803-001: INSPECTION ADDITIONAL WORK	
RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK	15.00
TOTAL MANHOURS	47.00
ELAPSED TIME (HOURS)	12.50

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FADAB given in Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK) .

Task 571131-833-804-001: REPAIR ADDITIONAL WORK	
On Aircraft	
Replace the Nuts on the LH Side, ADDITIONAL WORK	5.00
Replace the Nuts on the RH Side, ADDITIONAL WORK	5.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK	8.00
Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK	8.00
Tests	5.00
Close-Up	14.50
TOTAL MANHOURS	45.50
ELAPSED TIME (HOURS)	17.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-FAEAB given in Appendix 03 - Elapsed Time Assumption (ADDITIONAL WORK) .

****CONF ALL**

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

****CONF 001**

Aircraft Maintenance Manual (AMM)	06-20-00 20-28-00 28-11-00 28-21-54 53-35-11 57-27-12	12-34-24 28-00-00 28-21-00 28-25-00 57-17-11	20-21-11 28-10-00 28-21-42 32-12-00 57-27-11
Consumable Material List (CML)			

Drawing	R57102001		
Elec. Std. Practices Manual (ESPM)	20-55-00		
Non Destructive Test Manual (NTM)	51-10-01		
Service Bulletin (SB)	A320-57-1129 A320-57-1130		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-43-00	51-40-00 51-75-12	51-42-00

**CONF 002

Aircraft Maintenance Manual (AMM)	06-20-00 20-28-00 28-11-00 28-21-54 53-35-11 57-27-12	12-34-24 28-00-00 28-21-00 28-25-00 57-17-11	20-21-11 28-10-00 28-21-42 32-12-00 57-27-11
Consumable Material List (CML)			
Drawing	R57102001		
Elec. Std. Practices Manual (ESPM)	20-55-00		
Non Destructive Test Manual (NTM)	51-10-01		
Service Bulletin (SB)	A320-57-1129 A320-57-1130		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-43-00	51-40-00 51-75-12	51-42-00

**CONF ALL

K. PUBLICATION AFFECTED

None

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

2. MATERIAL INFORMATION

**CONF ALL

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

Customers with aircraft shown in the effectivity of this Service Bulletin should send a purchase order to AIRBUS. Quote the number of this Service Bulletin. The address is :

Kit 571131A06R04 Kit 571131A07R03 Supplementary kit 571131A06S01 Supplementary kit 571131A07S01	AIRBUS Material Logistics and Suppliers ATP ll B, Hein-Sass-Weg 24 21129 HAMBOURG Germany For ordering by internet: http://spares.airbus.com For ordering by E-mail : airbus.kit@airbus.com Telephone Hotline : +49 40 743 51660

AIRBUS Material, Logistics and Suppliers do not stock standard hardware as competitive multiple suppliers ensure access to minimum prices. AIRBUS recommends Customers with aircraft shown in the effectivity of this Service Bulletin to send a purchase order to KLX Aerospace Solutions. The address is:

Component COMPA01 Component COMPA03 Component COMPA04	KLX Aerospace Solutions. 10000 NW 15th Terrace Miami FL 33172 USA Tel EMEA: +49 (0) 40 822 285 31500 Tel US: +1 305 925 2600 Tel ASIA: +1 310 900 1300 Fax EMEA: +49 (0) 40 822 285 31010 Fax US: +1 305 507 7191 Fax ASIA: +1 310 819 1200 SITA: MIAMMCR E-Mail: AOGdesk@klx.com internet: http://www.KLXaerospace.com or, alternatively any other source on the open market.

(2) Price and Availability

Kit 571131A06R04	
Cost	3,230.00 USD
Availability	180 calendar days from receipt of order

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 571131A07R03	
Cost	3,160.00 USD
Availability	180 calendar days from receipt of order

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

Supplementary kit 571131A06S01	
Cost	1,890.00 USD
Availability	180 calendar days from receipt of order

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

Supplementary kit 571131A07S01	
Cost	1,730.00 USD
Availability	180 calendar days from receipt of order

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

B. INDUSTRY SUPPORT INFORMATION

For those aircraft with findings further to inspection as per this Service Bulletin, AIRBUS will provide the kits at no charge, and will credit the manhours for the correction at the operator's agreed in-house warranty labor rate upon receipt of a warranty claim.

C. LIST OF COMPONENTS

NOTE: This table shows the supplemental kits (S kits) needed to update the kits already held in your stock to the latest status.

Kit held by operator	Supplementary kit required	Latest status of kit
571131A06R02	571131A06S01	571131A06R04
571131A06R04	None	571131A06R04

NOTE: This table shows the supplemental kits (S kits) needed to update the kits already held in your stock to the latest status.

Kit held by operator	Supplementary kit required	Latest status of kit
571131A07R02	571131A07S01	571131A07R03
571131A07R03	None	571131A07R03

Kit 571131A06R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
10	ASNA2532-7	34	NUT				
11	ASNA2531-7	6	NUT				
13	ASNA2532-8	16	NUT				
15	ASNA2531-6	2	NUT				
60	EN6115T2-3	14	BOLT				
61	ASNA2536-2	17	NUT				
62	EN6115T2-2	3	BOLT				
65	NAS1149D0332K	8	WASHER				
	NSA5372-716AX	58	WASHER				
	NSA5372-716BX	58	WASHER				
	NSA5372-716CX	58	WASHER				
	NSA5372-716DX	58	WASHER				
	NSA5372-716EX	58	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

Kit 571131A07R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
10	ASNA2532-7	34	NUT				
11	ASNA2531-7	6	NUT				
13	ASNA2532-8	16	NUT				
15	ASNA2531-6	2	NUT				
60	EN6115T2-3	14	BOLT				
61	ASNA2536-2	17	NUT				
62	EN6115T2-2	3	BOLT				
65	NAS1149D0332K	8	WASHER				
	NSA5372-716AX	58	WASHER				
	NSA5372-716BX	58	WASHER				

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
	NSA5372-716CX	58	WASHER				
	NSA5372-716DX	58	WASHER				
	NSA5372-716EX	58	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

Supplementary kit 571131A06S01

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
10	ASNA2532-7	11	NUT				
11	ASNA2531-7	2	NUT				
13	ASNA2532-8	16	NUT				
15	ASNA2531-6	2	NUT				
60	EN6115T2-3	14	BOLT				
61	ASNA2536-2	17	NUT				
62	EN6115T2-2	3	BOLT				
65	NAS1149D0332K	8	WASHER				
	NSA5372-716AX	31	WASHER				
	NSA5372-716BX	31	WASHER				
	NSA5372-716CX	31	WASHER				
	NSA5372-716DX	31	WASHER				
	NSA5372-716EX	31	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

Supplementary kit 571131A07S01

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
10	ASNA2532-7	7	NUT				
11	ASNA2531-7	2	NUT				
13	ASNA2532-8	16	NUT				
15	ASNA2531-6	2	NUT				
60	EN6115T2-3	14	BOLT				
61	ASNA2536-2	17	NUT				
62	EN6115T2-2	3	BOLT				
65	NAS1149D0332K	8	WASHER				
	NSA5372-716AX	27	WASHER				
	NSA5372-716BX	27	WASHER				
	NSA5372-716CX	27	WASHER				
	NSA5372-716DX	27	WASHER				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
	NSA5372-716EX	27	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	
	Non Aqueous Cleaner	08BAA9	As required	

(2) Components

Component COMPA01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
11	ASNA2531-7	8	NUT				
31	ABS1418K8-13	4	SCREW				(1)
32	ABS1418K8-14	28	SCREW				(1)
33	ABS1418K8-18	32	SCREW				(1)
34	ABS1418K8-19	36	SCREW				(1)
35	ASNA2532-8	136	NUT				
36	ABS1418K8-21	8	SCREW				(1)
37	ABS1418K8-26	8	SCREW				(1)
38	ABS1418K8-17	24	SCREW				(1)
43	ABS1418K8-25	8	SCREW				(1)
44	ASNA2531-8	24	NUIT				
73	ABS1418K9-15	8	SCREW				(1)
74	ABS1418K9-16	32	SCREW				(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
75	ABS1418K9-17	24	SCREW				(1)
76	ASNA2532-9	64	NUT				
78	ABS1418K8-20	8	SCREW				(1)
80	ABS1418K7-23	8	SCREW				(1)
82	ABS1418K8-22	4	SCREW				(1)
	NSA5372-716AX	8	WASHER				
	NSA5372-716BX	8	WASHER				
	NSA5372-716EX	8	WASHER				
	NSA5372-816AX	160	WASHER				
	NSA5372-816BX	160	WASHER				
	NSA5372-816EX	160	WASHER				
	NSA5372-916AX	64	WASHER				
	NSA5372-916BX	64	WASHER				
	NSA5372-916EX	64	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Component COMPA03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
11	ASNA2531-7	4	NUT				
32	ABS1418K8-14	8	SCREW				(1)
34	ABS1418K8-19	8	SCREW				(1)
35	ASNA2532-8	22	NUT				
37	ABS1418K8-26	2	SCREW				(1)
43	ABS1418K8-25	2	SCREW				(1)
44	ASNA2531-8	4	NUIT				
73	ABS1418K9-15	4	SCREW				(1)
74	ABS1418K9-16	16	SCREW				(1)
75	ABS1418K9-17	12	SCREW				(1)
76	ASNA2532-9	32	NUT				
78	ABS1418K8-20	4	SCREW				(1)
80	ABS1418K7-23	4	SCREW				(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
82	ABS1418K8-22	2	SCREW				(1)
	NSA5372-716AX	4	WASHER				
	NSA5372-716BX	4	WASHER				
	NSA5372-716EX	4	WASHER				
	NSA5372-816AX	26	WASHER				
	NSA5372-816BX	26	WASHER				
	NSA5372-816EX	26	WASHER				
	NSA5372-916AX	32	WASHER				
	NSA5372-916BX	32	WASHER				
	NSA5372-916EX	32	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Component COMPA04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
11	ASNA2531-7	4	NUT				
34	ABS1418K8-19	8	SCREW				(1)
35	ASNA2532-8	14	NUT				
37	ABS1418K8-26	2	SCREW				(1)
43	ABS1418K8-25	2	SCREW				(1)
44	ASNA2531-8	4	NUIT				
73	ABS1418K9-15	4	SCREW				(1)
74	ABS1418K9-16	16	SCREW				(1)
75	ABS1418K9-17	12	SCREW				(1)
76	ASNA2532-9	32	NUT				
78	ABS1418K8-20	4	SCREW				(1)
80	ABS1418K7-23	4	SCREW				(1)
82	ABS1418K8-22	2	SCREW				(1)
	NSA5372-716AX	4	WASHER				
	NSA5372-716BX	4	WASHER				
	NSA5372-716EX	4	WASHER				
	NSA5372-816AX	18	WASHER				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
	NSA5372-816BX	18	WASHER				
	NSA5372-816EX	18	WASHER				
	NSA5372-916AX	32	WASHER				
	NSA5372-916BX	32	WASHER				
	NSA5372-916EX	32	WASHER				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Customers with aircraft shown in the effectivity of this Service Bulletin should send a purchase order to AIRBUS. Quote the number of this Service Bulletin. The address is :

Kit tool 571131T01R02 Kit tool 571131T02R00	AIRBUS MATERIAL SUPPORT CENTER P.O. Box 630262 22312 HAMBURG GERMANY

(b) Price and Availability

Kit tool 571131T01R02	
Cost	1,000.00 USD
Availability	42 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require the Kit(s) before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

Kit tool 571131T02R00	
Cost	1,364.00 USD
Availability	60 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require the Kit(s) before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

(2) Tools

(1) To accomplish this Service Bulletin it is necessary to use the following tools and equipment.

(a) For the taperlok installation test it is necessary to use the tool No. 98D57103001000 defined in Kit 571131T01R02 and the tool No. 98D57103002000 defined in Kit 571131T02R00.

(b) In case of finding, for the installation of the new taperlok it is necessary to use the drilling tool SOA-TL-R57102001B.

Procurement to be negotiated directly with :

S.O.A
International Managing Support
66 rue des Graves, BP30013
33326 EYSINES Cedex
Tel : +33.5.56.57.94.50
Fax : +33.5.56.28.95.17
Email: direction@soaweb.fr
FRANCE

(c) Equipment and materials for the rotating probe inspection of the holes, refer to NTM 51-10-01 Part 6.

(d) To accomplish this Service Bulletin it is necessary to use the tool 98D57004014000 listed in AMM 28-21-42, Page Block 401 and AMM 28-21-54, Page Block 401.

None

(3) Special Tools

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	6	

Kit tool 571131T02R00

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

3. ACCOMPLISHMENT INSTRUCTIONS

Task 571131-832-801-001 - INSPECTION

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS :

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC. AS NECESSARY ON WIRING AND COMPONENTS.

- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION, REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words "refer to" are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words "in accordance with" are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: The purpose of flow charts is to supplement the information given in the Procedure and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

****CONF 001**

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ

Manpower	
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

**CONF 002

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	69.00
ELAPSED TIME (HOURS)	18.00

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 571131-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00

(a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(c) Remove and install fasteners in accordance with SRM 51-42-00.

(2) Subtask 571131-839-003-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

**CONF 002

(1) **Subtask 571131-910-001-001 - Standard Practices**

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00

(a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(c) Remove and install fasteners in accordance with SRM 51-42-00.

(2) **Subtask 571131-839-003-001 - Administrative**

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

**CONF ALL

B. PREPARATION

**CONF 001

(1) **Subtask 571131-941-001-001 - Job Set-up**

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 28-00-00, Page Block 301 28-10-00, Page Block 301 28-25-00, Page Block 301 Task 32-12-00-010-001

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked

- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Put the access platform(s) in position.

(c) Defuel the center tank, refer to AMM 28-25-00 Page Block 301.

(d) Defuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(e) Degas and ventilate the center tank and the wing tanks, refer to AMM 28-00-00 Page Block 301 and AMM 28-10-00 Page Block 301.

(f) Open the main landing gear doors refer to AMM Task 32-12-00-010-001.

(2) Subtask 571131-010-001-001 - Remove/Open for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-001 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 147AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 540AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 540BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-001.

(f) If necessary, remove the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

(3) Subtask 571131-010-002-001 - Remove/Open for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-801 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 148AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 640AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 640BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-801.

(f) If necessary, remove the panels 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

****CONF 002**

(1) Subtask 571131-941-001-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 28-00-00, Page Block 301 28-10-00, Page Block 301 28-25-00, Page Block 301 Task 32-12-00-010-001

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Put the access platform(s) in position.

(c) Defuel the center tank, refer to AMM 28-25-00 Page Block 301.

(d) Defuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(e) Degas and ventilate the center tank and the wing tanks, refer to AMM 28-00-00 Page Block 301 and AMM 28-10-00 Page Block 301.

(f) Open the main landing gear doors refer to AMM Task 32-12-00-010-001.

(2) Subtask 571131-010-001-001 - Remove/Open for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-001 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 147AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 540AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 540BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-001.

(f) If necessary, remove the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

(3) Subtask 571131-010-002-001 - Remove/Open for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-801 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 148AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 640AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 640BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-801.

(f) If necessary, remove the panels 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 571131-832-006-001 - LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1

To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	26.00
Minimum number of person	2
Subtask elapsed time	13.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBAAA Inspection of the Fasteners	Sheet 01 Sheet 02 Sheet 03
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFAAA Flow Chart	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFAAA Sheet 01

Refer to Fig. A-FBAAA Sheet 01 to Fig. A-FBAAA Sheet 03

Refer to Fig. A-FBCAA Sheet 01

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

34	Nut	NSA5457-7E	Item (10)	Discard
	or			
34	Nut	NAS1727-7E	Item (10)	Discard
	or			
34	Nut	NSA5151-7	Item (10)	Discard
	and			
6	Nut	NAS1726-7E	Item (11)	Discard
	or			
6	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-019 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-019 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-017 001 Replace the Nuts on the LH Side before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-019 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-017 001 Replace the Nuts on the LH Side before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

(2) Subtask 571131-832-007-001 - RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	26.00
Minimum number of person	2
Subtask elapsed time	13.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBAAA Inspection of the Fasteners	Sheet 01 Sheet 02 Sheet 03
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFAAA Flow Chart	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFAAA Sheet 01

Refer to Fig. A-FBAAA Sheet 01 to Fig. A-FBAAA Sheet 03

Refer to Fig. A-FBCAA Sheet 01

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

34	Nut	NSA5457-7E	Item (10)	Discard
	or			
34	Nut	NAS1727-7E	Item (10)	Discard
	or			
34	Nut	NSA5151-7	Item (10)	Discard
	and			
6	Nut	NAS1726-7E	Item (11)	Discard
	or			
6	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-020 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-020 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-018 001 Replace the Nuts on the RH Side before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-020 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-018 001 Replace the Nuts on the RH Side before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

**CONF 002

(1) Subtask 571131-832-006-001 - LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	26.00
Minimum number of person	2
Subtask elapsed time	13.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBAAA Inspection of the Fasteners	Sheet 01 Sheet 02 Sheet 03
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFAAA Flow Chart	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFAAA Sheet 01

Refer to Fig. A-FBAAA Sheet 01 to Fig. A-FBAAA Sheet 03

Refer to Fig. A-FBCAA Sheet 01

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

34	Nut	NSA5457-7E	Item (10)	Discard
	or			
34	Nut	NAS1727-7E	Item (10)	Discard
	or			
34	Nut	NSA5151-7	Item (10)	Discard
	and			
6	Nut	NAS1726-7E	Item (11)	Discard
	or			
6	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-019 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-019 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-017 002 Replace the Nuts on the LH Side before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-019 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-017 002 Replace the Nuts on the LH Side before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

(2) Subtask 571131-832-007-001 - RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	26.00
Minimum number of person	2
Subtask elapsed time	13.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBAAA Inspection of the Fasteners	Sheet 01 Sheet 02 Sheet 03
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFAAA Flow Chart	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFAAA Sheet 01

Refer to Fig. A-FBAAA Sheet 01 to Fig. A-FBAAA Sheet 03

Refer to Fig. A-FBCAA Sheet 01

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

34	Nut	NSA5457-7E	Item (10)	Discard
	or			
34	Nut	NAS1727-7E	Item (10)	Discard
	or			
34	Nut	NSA5151-7	Item (10)	Discard
	and			
6	Nut	NAS1726-7E	Item (11)	Discard
	or			
6	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-020 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-020 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-018 002 Replace the Nuts on the RH Side before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-020 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-018 002 Replace the Nuts on the RH Side before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

**CONF ALL

D. TEST

**CONF 001

None

**CONF 002

None

**CONF ALL

E. CLOSE-UP

**CONF 001

None

**CONF 002

None

Task 571131-833-802-001 - REPAIR

****CONF ALL**

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS :

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC. AS NECESSARY ON WIRING AND COMPONENTS.

- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION, REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words "refer to" are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words "in accordance with" are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

Task Associated Data

****CONF 001**

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

**CONF 002

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	75.50
ELAPSED TIME (HOURS)	25.00

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 571131-910-002-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

(a) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(b) Apply sealant in accordance with SRM 51-24-00.

(c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(d) Remove and install fasteners in accordance with SRM 51-42-00.

(e) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(f) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.

(g) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00 "Mating Part" column.

(h) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(i) Repair of the paint coatings in accordance with SRM 51-75-12.

(2) Subtask 571131-839-002-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF 002**

(1) Subtask 571131-910-002-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

(a) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(b) Apply sealant in accordance with SRM 51-24-00.

(c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(d) Remove and install fasteners in accordance with SRM 51-42-00.

(e) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(f) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.

(g) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00 "Mating Part" column.

(h) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(i) Repair of the paint coatings in accordance with SRM 51-75-12.

(2) Subtask 571131-839-002-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF ALL**

B. PREPARATION

****CONF 001**

None

****CONF 002**

None

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 571131-833-017-001 - Replace the Nuts on the LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	12.00
Minimum number of person	2
Subtask elapsed time	6.00
Skills	AIRFRAME

Material necessary to do the job

Kit 571131A06R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	34	NUT	
11	ASNA2531-7	6	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	58	WASHER	
	NSA5372-716BX	58	WASHER	
	NSA5372-716CX	58	WASHER	
	NSA5372-716DX	58	WASHER	
	NSA5372-716EX	58	WASHER	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00.

Refer to Fig. A-FCAAA Sheet 01, Fig. A-FCAAA Sheet 02, Fig. A-FCAAA Sheet 05, Fig. A-FCAAA Sheet 06, Fig. A-FCAAA Sheet 07

34	Nut	ASNA2532-7	Item 10
6	Nut	ASNA2531-7	Item 11

16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
58	Washer	NSA5372-716AX	
	and/or		
58	Washer	NSA5372-716BX	
	and/or		
58	Washer	NSA5372-716CX	
	and/or		
58	Washer	NSA5372-716DX	
	and/or		
58	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(2) Subtask 571131-833-018-001 - Replace the Nuts on the RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	12.00
Minimum number of person	2
Subtask elapsed time	6.00
Skills	AIRFRAME

Material necessary to do the job

Kit 571131A06R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	34	NUT	
11	ASNA2531-7	6	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	58	WASHER	
	NSA5372-716BX	58	WASHER	
	NSA5372-716CX	58	WASHER	
	NSA5372-716DX	58	WASHER	
	NSA5372-716EX	58	WASHER	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00.

Refer to Fig. A-FCBAA Sheet 01, Fig. A-FCBAA Sheet 02, Fig. A-FCBAA Sheet 05, Fig. A-FCBAA Sheet 06, Fig. A-FCBAA Sheet 07

34	Nut	ASNA2532-7	Item 10
6	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
58	Washer	NSA5372-716AX	
	and/or		
58	Washer	NSA5372-716BX	
	and/or		
58	Washer	NSA5372-716CX	
	and/or		
58	Washer	NSA5372-716DX	
	and/or		
58	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(3) Subtask 571131-833-019-001 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	16.00
Minimum number of person	2
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 571131A06R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
31	ABS1418K8-13	1	SCREW	(1)
32	ABS1418K8-14	7	SCREW	(1)
33	ABS1418K8-18	8	SCREW	(1)
34	ABS1418K8-19	9	SCREW	(1)
35	ASNA2532-8	34	NUT	
36	ABS1418K8-21	2	SCREW	(1)
37	ABS1418K8-26	2	SCREW	(1)
38	ABS1418K8-17	6	SCREW	(1)
43	ABS1418K8-25	2	SCREW	(1)
44	ASNA2531-8	6	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	40	WASHER	
	NSA5372-816BX	40	WASHER	
	NSA5372-816EX	40	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6

References	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (53)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (51)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (50)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

6	Screw	Item (16)	Discard
10	Screw	Item (5)	Discard
9	Screw	Item (7)	Discard
7	Screw	Item (3)	Discard
2	Screw	Item (14)	Discard
1	Screw	Item (1)	Discard
2	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks, refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000 Test specimen 1

(e) Depending on the removal, install :

Refer to Fig. A-FCAAA Sheet 01, Fig. A-FCAAA Sheet 02, Fig. A-FCAAA Sheet 05, Fig. A-FCAAA Sheet 06, Fig. A-FCAAA Sheet 07

6	Screw	ABS1418K8-17	Item 38
8	Screw	ABS1418K8-18	Item 33
9	Screw	ABS1418K8-19	Item 34
1	Screw	ABS1418K8-13	Item 31
7	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
34	Nut	ASNA2532-8	Item 35
	and if necessary		
34	Washer	NSA5372-816AX	
	and/or		
34	Washer	NSA5372-816EX	
	and/or		
34	Washer	NSA5372-816BX	
	and		

2	Screw	ABS1418K8-25	Item 43
2	Screw	ABS1418K8-26	Item 37
2	Screw	ABS1418K8-21	Item 36
	with		
6	Nut	ASNA2531-8	Item 44
	and if necessary		
6	Washer	NSA5372-816AX	
	and/or		
6	Washer	NSA5372-816EX	
	and/or		
6	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		

2	Washer	NSA5372-716AX
	and/or	
2	Washer	NSA5372-716EX
	and/or	
2	Washer	NSA5372-716BX

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (51)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (50)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (53)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

(4) Subtask 571131-833-020-001 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	16.00
Minimum number of person	2
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 571131A06R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
31	ABS1418K8-13	1	SCREW	(1)
32	ABS1418K8-14	7	SCREW	(1)
33	ABS1418K8-18	8	SCREW	(1)
34	ABS1418K8-19	9	SCREW	(1)
35	ASNA2532-8	34	NUT	
36	ABS1418K8-21	2	SCREW	(1)
37	ABS1418K8-26	2	SCREW	(1)
38	ABS1418K8-17	6	SCREW	(1)
43	ABS1418K8-25	2	SCREW	(1)
44	ASNA2531-8	6	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	40	WASHER	
	NSA5372-816BX	40	WASHER	
	NSA5372-816EX	40	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6

References	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (54)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (171)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (170)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

6	Screw	Item (16)	Discard
10	Screw	Item (5)	Discard
9	Screw	Item (7)	Discard
7	Screw	Item (3)	Discard
2	Screw	Item (14)	Discard
1	Screw	Item (1)	Discard
2	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000 Test specimen 1

(e) Depending on the removal, install :

Refer to Fig. A-FCBAA Sheet 01, Fig. A-FCBAA Sheet 02, Fig. A-FCBAA Sheet 05, Fig. A-FCBAA Sheet 06, Fig. A-FCBAA Sheet 07

6	Screw	ABS1418K8-17	Item 38
8	Screw	ABS1418K8-18	Item 33
9	Screw	ABS1418K8-19	Item 34
1	Screw	ABS1418K8-13	Item 31
7	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
34	Nut	ASNA2532-8	Item 35
	and if necessary		
34	Washer	NSA5372-816AX	
	and/or		
34	Washer	NSA5372-816EX	
	and/or		
34	Washer	NSA5372-816BX	
	and		

2	Screw	ABS1418K8-25	Item 43
2	Screw	ABS1418K8-26	Item 37
2	Screw	ABS1418K8-21	Item 36
	with		
6	Nut	ASNA2531-8	Item 44
	and if necessary		
6	Washer	NSA5372-816AX	
	and/or		
6	Washer	NSA5372-816EX	
	and/or		
6	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		

2	Washer	NSA5372-716AX
	and/or	
2	Washer	NSA5372-716EX
	and/or	
2	Washer	NSA5372-716BX

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592l bf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (171)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (170)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (54)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

**CONF 002

(1) Subtask 571131-833-017-002 - Replace the Nuts on the LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	12.00
Minimum number of person	2
Subtask elapsed time	6.00
Skills	AIRFRAME

Material necessary to do the job

Kit 571131A07R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	34	NUT	
11	ASNA2531-7	6	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	58	WASHER	
	NSA5372-716BX	58	WASHER	
	NSA5372-716CX	58	WASHER	
	NSA5372-716DX	58	WASHER	
	NSA5372-716EX	58	WASHER	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00

References	
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00.

Refer to Fig. A-FCAAA Sheet 01, Fig. A-FCAAA Sheet 02, Fig. A-FCAAA Sheet 05, Fig. A-FCAAA Sheet 06, Fig. A-FCAAA Sheet 07

34	Nut	ASNA2532-7	Item 10
6	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
58	Washer	NSA5372-716AX	
	and/or		
58	Washer	NSA5372-716BX	
	and/or		
58	Washer	NSA5372-716CX	
	and/or		
58	Washer	NSA5372-716DX	
	and/or		
58	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(2) Subtask 571131-833-018-002 - Replace the Nuts on the RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	12.00
Minimum number of person	2
Subtask elapsed time	6.00
Skills	AIRFRAME

Material necessary to do the job

Kit 571131A07R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	34	NUT	
11	ASNA2531-7	6	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	58	WASHER	
	NSA5372-716BX	58	WASHER	
	NSA5372-716CX	58	WASHER	
	NSA5372-716DX	58	WASHER	
	NSA5372-716EX	58	WASHER	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00.

Refer to Fig. A-FCBAA Sheet 01, Fig. A-FCBAA Sheet 02, Fig. A-FCBAA Sheet 05, Fig. A-FCBAA Sheet 06, Fig. A-FCBAA Sheet 07

34	Nut	ASNA2532-7	Item 10
6	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
58	Washer	NSA5372-716AX	
	and/or		
58	Washer	NSA5372-716BX	
	and/or		
58	Washer	NSA5372-716CX	
	and/or		
58	Washer	NSA5372-716DX	
	and/or		
58	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(3) Subtask 571131-833-019-002 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	16.00
Minimum number of person	2
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 571131A07R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
31	ABS1418K8-13	1	SCREW	(1)
32	ABS1418K8-14	7	SCREW	(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
33	ABS1418K8-18	8	SCREW	(1)
34	ABS1418K8-19	9	SCREW	(1)
35	ASNA2532-8	34	NUT	
36	ABS1418K8-21	2	SCREW	(1)
37	ABS1418K8-26	2	SCREW	(1)
38	ABS1418K8-17	6	SCREW	(1)
43	ABS1418K8-25	2	SCREW	(1)
44	ASNA2531-8	6	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	40	WASHER	
	NSA5372-816BX	40	WASHER	
	NSA5372-816EX	40	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCAAA LH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (53)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (51)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (50)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCAAA Sheet 01 to Fig. A-FCAAA Sheet 04

6	Screw	Item (16)	Discard
10	Screw	Item (5)	Discard
9	Screw	Item (7)	Discard
7	Screw	Item (3)	Discard
2	Screw	Item (14)	Discard
1	Screw	Item (1)	Discard

2	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks, refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000 Test specimen 1

(e) Depending on the removal, install :

Refer to Fig. A-FCAAA Sheet 01, Fig. A-FCAAA Sheet 02, Fig. A-FCAAA Sheet 05, Fig. A-FCAAA Sheet 06, Fig. A-FCAAA Sheet 07

6	Screw	ABS1418K8-17	Item 38
8	Screw	ABS1418K8-18	Item 33
9	Screw	ABS1418K8-19	Item 34
1	Screw	ABS1418K8-13	Item 31
7	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82

with

34	Nut	ASNA2532-8	Item 35
	and if necessary		
34	Washer	NSA5372-816AX	
	and/or		
34	Washer	NSA5372-816EX	
	and/or		
34	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K8-25	Item 43
2	Screw	ABS1418K8-26	Item 37
2	Screw	ABS1418K8-21	Item 36
	with		
6	Nut	ASNA2531-8	Item 44
	and if necessary		
6	Washer	NSA5372-816AX	
	and/or		
6	Washer	NSA5372-816EX	
	and/or		
6	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		

16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		
2	Washer	NSA5372-716BX	

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (51)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (50)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (53)	Retained at removal
1	Duct	Item (52)	Retained at removal
	with		

1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

(4) Subtask 571131-833-020-002 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	16.00
Minimum number of person	2
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 571131A07R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
31	ABS1418K8-13	1	SCREW	(1)
32	ABS1418K8-14	7	SCREW	(1)
33	ABS1418K8-18	8	SCREW	(1)
34	ABS1418K8-19	9	SCREW	(1)
35	ASNA2532-8	34	NUT	
36	ABS1418K8-21	2	SCREW	(1)
37	ABS1418K8-26	2	SCREW	(1)
38	ABS1418K8-17	6	SCREW	(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
43	ABS1418K8-25	2	SCREW	(1)
44	ASNA2531-8	6	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	40	WASHER	
	NSA5372-816BX	40	WASHER	
	NSA5372-816EX	40	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCBAA RH Side, Replacement of the Lower Panel Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (54)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain

8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (171)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (170)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCBAA Sheet 01 to Fig. A-FCBAA Sheet 04

6	Screw	Item (16)	Discard
10	Screw	Item (5)	Discard
9	Screw	Item (7)	Discard
7	Screw	Item (3)	Discard
2	Screw	Item (14)	Discard
1	Screw	Item (1)	Discard
2	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard

6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000	Test specimen	1

(e) Depending on the removal, install :

Refer to Fig. A-FCBAA Sheet 01, Fig. A-FCBAA Sheet 02, Fig. A-FCBAA Sheet 05, Fig. A-FCBAA Sheet 06, Fig. A-FCBAA Sheet 07

6	Screw	ABS1418K8-17	Item 38
8	Screw	ABS1418K8-18	Item 33
9	Screw	ABS1418K8-19	Item 34
1	Screw	ABS1418K8-13	Item 31
7	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
34	Nut	ASNA2532-8	Item 35
	and if necessary		
34	Washer	NSA5372-816AX	
	and/or		

34	Washer	NSA5372-816EX	
	and/or		
34	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K8-25	Item 43
2	Screw	ABS1418K8-26	Item 37
2	Screw	ABS1418K8-21	Item 36
	with		
6	Nut	ASNA2531-8	Item 44
	and if necessary		
6	Washer	NSA5372-816AX	
	and/or		
6	Washer	NSA5372-816EX	
	and/or		
6	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		

2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		
2	Washer	NSA5372-716BX	

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (171)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (170)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (54)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

**CONF ALL

D. TEST

**CONF 001

(1) Subtask 571131-710-002-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-720-005 Task 20-28-00-869-002 Task 28-11-00-280-002 Task 28-21-00-710-006 Task 57-17-11-400-001 Task 57-27-11-400-001

(a) Job Set-up :

1 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(b) Test :

1 Do the test procedure as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Do the test procedure as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

3 Do a fuel tanks leak checks (only leak test of the center tank or/and leak test of the wing tanks - without fuel - by the local blowing procedure), refer to AMM Task 28-11-00-280-002.

NOTE: Do this test on the taperlok bolts inspected by this Service Bulletin.

4 For all the access panels and covers removed during the preparation procedure, do a check of the electrical bonding (external metal surfaces/parts (hinges or fixed)) refer to AMM Task 20-28-00-720-005.

NOTE: For the maximum permitted resistance values : refer to the table AMM Task 20-28-00-869-002.

**CONF 002

(1) Subtask 571131-710-002-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-720-005 Task 20-28-00-869-002 Task 28-11-00-280-002 Task 28-21-00-710-006 Task 57-17-11-400-001 Task 57-27-11-400-001

(a) Job Set-up :

1 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(b) Test :

1 Do the test procedure as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Do the test procedure as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

3 Do a fuel tanks leak checks (only leak test of the center tank or/and leak test of the wing tanks - without fuel - by the local blowing procedure), refer to AMM Task 28-11-00-280-002.

NOTE: Do this test on the taperlok bolts inspected by this Service Bulletin.

4 For all the access panels and covers removed during the preparation procedure, do a check of the electrical bonding (external metal surfaces/parts (hinges or fixed)) refer to AMM Task 20-28-00-720-005.

NOTE: For the maximum permitted resistance values : refer to the table AMM Task 20-28-00-869-002.

**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 571131-410-003-001 - Install/Close Items Removed/Opened for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 540BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 540AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 147AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(2) Subtask 571131-410-004-001 - Install/Close Items Removed/Opened for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001

References	
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 640BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 640AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 148AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels , 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(3) Subtask 571131-942-002-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	28-25-00, Page Block 301 Task 32-12-00-410-001

(a) Refuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(b) Refuel the center tank, refer to AMM 28-25-00 Page Block 301.

(c) Close the main landing gear doors, refer to AMM Task 32-12-00-410-001.

(d) Remove the access platform(s).

(e) Put the aircraft back to its initial configuration.

****CONF 002**

(1) Subtask 571131-410-003-001 - Install/Close Items Removed/Opened for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 540BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 540AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 147AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(2) Subtask 571131-410-004-001 - Install/Close Items Removed/Opened for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 640BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 640AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 148AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels , 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(3) Subtask 571131-942-002-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	28-25-00, Page Block 301 Task 32-12-00-410-001

(a) Refuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(b) Refuel the center tank, refer to AMM 28-25-00 Page Block 301.

(c) Close the main landing gear doors, refer to AMM Task 32-12-00-410-001.

(d) Remove the access platform(s).

(e) Put the aircraft back to its initial configuration.

Task 571131-832-803-001 - INSPECTION ADDITIONAL WORK

****CONF ALL**

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS :

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC. AS NECESSARY ON WIRING AND COMPONENTS.
- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION, REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words "refer to" are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words "in accordance with" are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: The purpose of flow charts is to supplement the information given in the Procedure and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

****CONF 001**

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ

Manpower	
TOTAL MANHOURS	51.00
ELAPSED TIME (HOURS)	13.50

**CONF 002

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	47.00
ELAPSED TIME (HOURS)	12.50

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 571131-910-003-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00

(a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(c) Remove and install fasteners in accordance with SRM 51-42-00.

(2) Subtask 571131-839-005-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

**CONF 002

(1) Subtask 571131-910-003-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00

(a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(c) Remove and install fasteners in accordance with SRM 51-42-00.

(2) Subtask 571131-839-005-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

**CONF ALL

B. PREPARATION

**CONF 001

(1) Subtask 571131-941-002-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 28-00-00, Page Block 301 28-10-00, Page Block 301 28-25-00, Page Block 301 Task 32-12-00-010-001

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked

- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Put the access platform(s) in position.

(c) Defuel the center tank, refer to AMM 28-25-00 Page Block 301.

(d) Defuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(e) Degas and ventilate the center tank and the wing tanks, refer to AMM 28-00-00 Page Block 301 and AMM 28-10-00 Page Block 301.

(f) Open the main landing gear doors refer to AMM Task 32-12-00-010-001.

(2) Subtask 571131-010-003-001 - Remove/Open for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-001 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 147AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 540AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 540BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-001.

(f) If necessary, remove the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

(3) Subtask 571131-010-004-001 - Remove/Open for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-801 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 148AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 640AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 640BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-801.

(f) If necessary, remove the panels 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

****CONF 002**

(1) Subtask 571131-941-002-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 28-00-00, Page Block 301 28-10-00, Page Block 301 28-25-00, Page Block 301 Task 32-12-00-010-001

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Put the access platform(s) in position.

(c) Defuel the center tank, refer to AMM 28-25-00 Page Block 301.

(d) Defuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(e) Degas and ventilate the center tank and the wing tanks, refer to AMM 28-00-00 Page Block 301 and AMM 28-10-00 Page Block 301.

(f) Open the main landing gear doors refer to AMM Task 32-12-00-010-001.

(2) Subtask 571131-010-003-001 - Remove/Open for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-001 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 147AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 540AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 540BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-001.

(f) If necessary, remove the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

(3) Subtask 571131-010-004-001 - Remove/Open for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-000-001 Task 28-21-54-000-801 Task 53-35-11-000-001 Task 57-17-11-000-001 Task 57-27-11-000-001 Task 57-27-12-000-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Remove the access cover 148AZ, refer to AMM Task 57-17-11-000-001.

(b) Remove the wing access panel 640AB, refer to AMM Task 57-27-11-000-001.

(c) Open the fuel surge access door 640BZ, refer to AMM Task 57-27-12-000-001.

(d) Remove the fuel pump suction valve, refer to AMM Task 28-21-42-000-001.

(e) Remove the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-000-801.

(f) If necessary, remove the panels 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-000-001.

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 571131-832-008-001 - LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1

To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	17.00
Minimum number of person	2
Subtask elapsed time	8.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCEAA Inspection of the Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFBAA Flow Chart for the ADDITIONAL WORK	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFBAA Sheet 01

Refer to Fig. A-FBCAA Sheet 01.

Refer to Fig. A-FCEAA Sheet 01 to Fig. A-FCEAA Sheet 03

Refer to Fig. A-FCFAA Sheet 01 to Fig. A-FCFAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCFAA Sheet 01 to Fig. A-FCFAA Sheet 04

11	Nut	NSA5457-7E	Item (10)	Discard
	or			
11	Nut	NAS1727-7E	Item (10)	Discard
	or			
11	Nut	NSA5151-7	Item (10)	Discard
	and			
2	Nut	NAS1726-7E	Item (11)	Discard
	or			
2	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-023 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-023 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-021 001 Replace the Nuts on the LH Side, ADDITIONAL WORK before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-023 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-021 001 Replace the Nuts on the LH Side, ADDITIONAL WORK before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

(2) Subtask 571131-832-009-001 - RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	17.00
Minimum number of person	2
Subtask elapsed time	8.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCEAA Inspection of the Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCGAA RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFBAA Flow Chart for the ADDITIONAL WORK	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFBAA Sheet 01

Refer to Fig. A-FBCAA Sheet 01.

Refer to Fig. A-FCEAA Sheet 01 to Fig. A-FCEAA Sheet 03

Refer to Fig. A-FCGAA Sheet 01 to Fig. A-FCGAA Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCGAA Sheet 01 to Fig. A-FCGAA Sheet 04

11	Nut	NSA5457-7E	Item (10)	Discard
	or			
11	Nut	NAS1727-7E	Item (10)	Discard
	or			
11	Nut	NSA5151-7	Item (10)	Discard
	and			
2	Nut	NAS1726-7E	Item (11)	Discard
	or			
2	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-024 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-024 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-022 001 Replace the Nuts on the RH Side, ADDITIONAL WORK before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-024 001 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-022 001 Replace the Nuts on the RH Side, ADDITIONAL WORK before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

**CONF 002

(1) Subtask 571131-832-008-002 - LH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	15.00
Minimum number of person	2
Subtask elapsed time	7.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCEAB Inspection of the Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FFBAB Flow Chart for the ADDITIONAL WORK	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFBAB Sheet 01

Refer to Fig. A-FBCAA Sheet 01.

Refer to Fig. A-FCEAB Sheet 01 to Fig. A-FCEAB Sheet 03

Refer to Fig. A-FCFAB Sheet 01 to Fig. A-FCFAB Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCFAB Sheet 01 to Fig. A-FCFAB Sheet 04

7	Nut	NSA5457-7E	Item (10)	Discard
	or			
7	Nut	NAS1727-7E	Item (10)	Discard
	or			
7	Nut	NSA5151-7	Item (10)	Discard
	and			
2	Nut	NAS1726-7E	Item (11)	Discard
	or			
2	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-023 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-023 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-021 002 Replace the Nuts on the LH Side, ADDITIONAL WORK before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-023 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-021 002 Replace the Nuts on the LH Side, ADDITIONAL WORK before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

(2) Subtask 571131-832-009-002 - RH Side, do a Detailed Inspection in Center and Outer Wing Box at Level of Rib1 junction, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	15.00
Minimum number of person	2
Subtask elapsed time	7.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner	08BAA9	As required	

Kit tool 571131T01R02

ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103001000	Gage	1	

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-FBCAA Thread Damage	Sheet 01
Fig. A-FCGAB RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-FCEAB Inspection of the Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03
Fig. A-FFBAB Flow Chart for the ADDITIONAL WORK	Sheet 01
Fig. A-FRAAA Inspection Report	Sheet 01

(a) Do a detailed inspection of lower panels in center and outer wing box at level of rib1 junction:

In accordance with SRM 51-42-00

Refer to Fig. A-FFBAB Sheet 01

Refer to Fig. A-FBCAA Sheet 01.

Refer to Fig. A-FCEAB Sheet 01 to Fig. A-FCEAB Sheet 03

Refer to Fig. A-FCGAB Sheet 01 to Fig. A-FCGAB Sheet 04

1 Remove the sealant on the nuts with:

Non Aqueous Cleaner	08BAA9	As required

2 Remove the nuts :

Refer to Fig. A-FCGAB Sheet 01 to Fig. A-FCGAB Sheet 04

7	Nut	NSA5457-7E	Item (10)	Discard
	or			
7	Nut	NAS1727-7E	Item (10)	Discard
	or			
7	Nut	NSA5151-7	Item (10)	Discard
	and			
2	Nut	NAS1726-7E	Item (11)	Discard
	or			
2	Nut	NSA5050-7	Item (11)	Discard
	and			
16	Nut	NSA5457-8E	Item (13)	Discard
	or			
16	Nut	NAS1727-8E	Item (13)	Discard
	or			
16	Nut	NSA5151-8	Item (13)	Discard
	and			
2	Nut	NAS1726-6E	Item (15)	Discard
	or			
2	Nut	NSA5050-6	Item (15)	Discard

NOTE: Identify the location of each removed nut.

(b) Check if the taperlok gage fit and move as described in the gage set procedure:

98D57103001000	Gage set	1

1 If taperlok gage fit and move:

a Do a visual inspection of the thread to determine the cause of thread marks found:

<1> If thread marks are found caused by an incorrect installation:

<a> Apply SUBTASK 571131-833-024 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

<2> If no thread marks are found caused by an incorrect installation but thread was damaged during the nut removal:

<a> Apply SUBTASK 571131-833-024 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

<3> If no thread marks are found caused by an incorrect installation and thread was not damaged during the nut removal:

<a> Apply SUBTASK 571131-833-022 002 Replace the Nuts on the RH Side, ADDITIONAL WORK before next flight.

2 If the taperlok gage do not fit and move but thread was damaged during the nut removal:

a Apply SUBTASK 571131-833-024 002 Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK before next flight.

3 If the taperlok gage do not fit and move and thread was not damaged during the nut removal:

a Apply SUBTASK 571131-833-022 002 Replace the Nuts on the RH Side, ADDITIONAL WORK before next flight.

(c) For the inspection report, refer to Fig. A-FRAAA.

**CONF ALL

D. TEST

**CONF 001

None

**CONF 002

None

**CONF ALL

E. CLOSE-UP

**CONF 001

None

**CONF 002

None

Task 571131-833-804-001 - REPAIR ADDITIONAL WORK

****CONF ALL**

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS :

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC. AS NECESSARY ON WIRING AND COMPONENTS.
- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION, REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words "refer to" are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words "in accordance with" are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

Task Associated Data

****CONF 001**

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	53.50
ELAPSED TIME (HOURS)	19.00

**CONF 002

Zone	
From 141 to 540 From 142 to 640	
Access	
Panel	147AZ 148AZ 540AB 540BZ 640AB 640BZ
Manpower	
TOTAL MANHOURS	45.50
ELAPSED TIME (HOURS)	17.00

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 571131-910-004-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

(a) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(b) Apply sealant in accordance with SRM 51-24-00.

(c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(d) Remove and install fasteners in accordance with SRM 51-42-00.

(e) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.

(f) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00 "Mating Part" column.

(g) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(h) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(i) Repair of the paint coatings in accordance with SRM 51-75-12.

(2) Subtask 571131-839-004-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF 002**

(1) Subtask 571131-910-004-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

(a) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(b) Apply sealant in accordance with SRM 51-24-00.

(c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).

(d) Remove and install fasteners in accordance with SRM 51-42-00.

(e) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.

(f) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00 "Mating Part" column.

(g) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(h) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(i) Repair of the paint coatings in accordance with SRM 51-75-12.

(2) Subtask 571131-839-004-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF ALL**

B. PREPARATION

****CONF 001**

None

****CONF 002**

None

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 571131-833-021-001 - Replace the Nuts on the LH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	7.00
Minimum number of person	2
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Supplementary kit 571131A06S01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	11	NUT	
11	ASNA2531-7	2	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	31	WASHER	
	NSA5372-716BX	31	WASHER	
	NSA5372-716CX	31	WASHER	
	NSA5372-716DX	31	WASHER	
	NSA5372-716EX	31	WASHER	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to Fig. A-FCFAA Sheet 01, Fig. A-FCFAA Sheet 02, Fig. A-FCFAA Sheet 05, Fig. A-FCFAA Sheet 06, Fig. A-FCFAA Sheet 07

11	Nut	ASNA2532-7	Item 10
2	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15

with

31	Washer	NSA5372-716AX
	and/or	
31	Washer	NSA5372-716BX
	and/or	
31	Washer	NSA5372-716CX
	and/or	
31	Washer	NSA5372-716DX
	and/or	
31	Washer	NSA5372-716EX

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(2) Subtask 571131-833-022-001 - Replace the Nuts on the RH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	7.00
Minimum number of person	2
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Supplementary kit 571131A06S01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	11	NUT	
11	ASNA2531-7	2	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	31	WASHER	
	NSA5372-716BX	31	WASHER	
	NSA5372-716CX	31	WASHER	
	NSA5372-716DX	31	WASHER	
	NSA5372-716EX	31	WASHER	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCGAA RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to Fig. A-FCGAA Sheet 01, Fig. A-FCGAA Sheet 02, Fig. A-FCGAA Sheet 05, Fig. A-FCGAA Sheet 06, Fig. A-FCGAA Sheet 07

11	Nut	ASNA2532-7	Item 10
2	Nut	ASNA2531-7	Item 11

16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
31	Washer	NSA5372-716AX	
	and/or		
31	Washer	NSA5372-716BX	
	and/or		
31	Washer	NSA5372-716CX	
	and/or		
31	Washer	NSA5372-716DX	
	and/or		
31	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(3) Subtask 571131-833-023-001 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Supplementary kit 571131A06S01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
32	ABS1418K8-14	4	SCREW	(1)
34	ABS1418K8-19	4	SCREW	(1)
35	ASNA2532-8	11	NUT	
37	ABS1418K8-26	1	SCREW	(1)
43	ABS1418K8-25	1	SCREW	(1)
44	ASNA2531-8	2	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	13	WASHER	
	NSA5372-816BX	13	WASHER	
	NSA5372-816EX	13	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03

References	
Fig. A-FCFAA LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCFAA Sheet 01 to Fig. A-FCFAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (53)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (51)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (50)	Retain

attached with

7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCFAA Sheet 01 to Fig. A-FCFAA Sheet 04

4	Screw	Item (7)	Discard
4	Screw	Item (3)	Discard
1	Screw	Item (14)	Discard
1	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks, refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000	Test specimen	1

(e) Depending on the removal, install :

Refer to Fig. A-FCFAA Sheet 01, Fig. A-FCFAA Sheet 02, Fig. A-FCFAA Sheet 05, Fig. A-FCFAA Sheet 06, Fig. A-FCFAA Sheet 07

4	Screw	ABS1418K8-19	Item 34
4	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
11	Nut	ASNA2532-8	Item 35
	and if necessary		
11	Washer	NSA5372-816AX	
	and/or		
11	Washer	NSA5372-816EX	
	and/or		
11	Washer	NSA5372-816BX	
	and		
1	Screw	ABS1418K8-25	Item 43
1	Screw	ABS1418K8-26	Item 37
	with		
2	Nut	ASNA2531-8	Item 44
	and if necessary		
2	Washer	NSA5372-816AX	
	and/or		
2	Washer	NSA5372-816EX	
	and/or		
2	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		

16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		
2	Washer	NSA5372-716BX	

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant- Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter- For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (51)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (50)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant- General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (53)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

(4) Subtask 571131-833-024-001 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Supplementary kit 571131A06S01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
32	ABS1418K8-14	4	SCREW	(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	ABS1418K8-19	4	SCREW	(1)
35	ASNA2532-8	11	NUT	
37	ABS1418K8-26	1	SCREW	(1)
43	ABS1418K8-25	1	SCREW	(1)
44	ASNA2531-8	2	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	13	WASHER	
	NSA5372-816BX	13	WASHER	
	NSA5372-816EX	13	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCGAA RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCGAA Sheet 01 to Fig. A-FCGAA Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (54)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain

8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (171)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (170)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCGAA Sheet 01 to Fig. A-FCGAA Sheet 04

4	Screw	Item (7)	Discard
4	Screw	Item (3)	Discard
1	Screw	Item (14)	Discard
1	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard

1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000	Test specimen	1

(e) Depending on the removal, install :

Refer to Fig. A-FCGAA Sheet 01, Fig. A-FCGAA Sheet 02, Fig. A-FCGAA Sheet 05, Fig. A-FCGAA Sheet 06, Fig. A-FCGAA Sheet 07

4	Screw	ABS1418K8-19	Item 34
4	Screw	ABS1418K8-14	Item 32
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
11	Nut	ASNA2532-8	Item 35
	and if necessary		
11	Washer	NSA5372-816AX	
	and/or		
11	Washer	NSA5372-816EX	
	and/or		
11	Washer	NSA5372-816BX	
	and		
1	Screw	ABS1418K8-25	Item 43
1	Screw	ABS1418K8-26	Item 37
	with		

2	Nut	ASNA2531-8	Item 44
	and if necessary		
2	Washer	NSA5372-816AX	
	and/or		
2	Washer	NSA5372-816EX	
	and/or		
2	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		

2	Washer	NSA5372-716BX

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (171)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	

10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (170)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (54)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

****CONF 002**

(1) Subtask 571131-833-021-002 - Replace the Nuts on the LH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	5.00
Minimum number of person	2
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Supplementary kit 571131A07S01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	7	NUT	
11	ASNA2531-7	2	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	27	WASHER	
	NSA5372-716BX	27	WASHER	
	NSA5372-716CX	27	WASHER	
	NSA5372-716DX	27	WASHER	
	NSA5372-716EX	27	WASHER	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to Fig. A-FCFAB Sheet 01, Fig. A-FCFAB Sheet 02, Fig. A-FCFAB Sheet 05, Fig. A-FCFAB Sheet 06, Fig. A-FCFAB Sheet 07

7	Nut	ASNA2532-7	Item 10
2	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
27	Washer	NSA5372-716AX	
	and/or		
27	Washer	NSA5372-716BX	
	and/or		
27	Washer	NSA5372-716CX	
	and/or		
27	Washer	NSA5372-716DX	
	and/or		
27	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(2) Subtask 571131-833-022-002 - Replace the Nuts on the RH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	5.00
Minimum number of person	2
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Supplementary kit 571131A07S01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ASNA2532-7	7	NUT	
11	ASNA2531-7	2	NUT	
13	ASNA2532-8	16	NUT	
15	ASNA2531-6	2	NUT	
	NSA5372-716AX	27	WASHER	
	NSA5372-716BX	27	WASHER	
	NSA5372-716CX	27	WASHER	
	NSA5372-716DX	27	WASHER	
	NSA5372-716EX	27	WASHER	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

References	
Structural Repair Manual (SRM)	51-40-00 51-42-00 51-43-00
Fig. A-FCCAA Definition of the Washer Thickness for the Original Taperlok	Sheet 01 Sheet 02 Sheet 03

References	
Fig. A-FCGAB RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

NOTE: The nuts are removed during the inspection.

(a) Install the nuts.

In accordance with SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to Fig. A-FCGAB Sheet 01, Fig. A-FCGAB Sheet 02, Fig. A-FCGAB Sheet 05, Fig. A-FCGAB Sheet 06, Fig. A-FCGAB Sheet 07

7	Nut	ASNA2532-7	Item 10
2	Nut	ASNA2531-7	Item 11
16	Nut	ASNA2532-8	Item 13
2	Nut	ASNA2531-6	Item 15
	with		
27	Washer	NSA5372-716AX	
	and/or		
27	Washer	NSA5372-716BX	
	and/or		
27	Washer	NSA5372-716CX	
	and/or		
27	Washer	NSA5372-716DX	
	and/or		
27	Washer	NSA5372-716EX	

NOTE: Install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCCAA Sheet 01.

NOTE: If necessary, the installation of the three washers is approved in this condition.

NOTE: Torque the nuts between 3.80 daN and 4.60 daN (342 lbf.in. and 411 lbf.in.).

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(3) Subtask 571131-833-023-002 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the LH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	141	Access	Panel 147AZ
		Work location	Rib 1
To	540	Access	Panel 540AB, Panel 540BZ
		Work location	Rib 1

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	5.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Supplementary kit 571131A07S01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
34	ABS1418K8-19	4	SCREW	(1)
35	ASNA2532-8	7	NUT	
37	ABS1418K8-26	1	SCREW	(1)
43	ABS1418K8-25	1	SCREW	(1)
44	ASNA2531-8	2	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	9	WASHER	
	NSA5372-816BX	9	WASHER	
	NSA5372-816EX	9	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001

References	
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCFAB Sheet 01 to Fig. A-FCFAB Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (53)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (51)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (50)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCFAB Sheet 01 to Fig. A-FCFAB Sheet 04

4	Screw	Item (7)	Discard
1	Screw	Item (14)	Discard
1	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks, refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000	Test specimen	1

(e) Depending on the removal, install :

Refer to Fig. A-FCFAB Sheet 01, Fig. A-FCFAB Sheet 02, Fig. A-FCFAB Sheet 05, Fig. A-FCFAB Sheet 06, Fig. A-FCFAB Sheet 07

4	Screw	ABS1418K8-19	Item 34
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
7	Nut	ASNA2532-8	Item 35
	and if necessary		
7	Washer	NSA5372-816AX	
	and/or		
7	Washer	NSA5372-816EX	
	and/or		
7	Washer	NSA5372-816BX	
	and		
1	Screw	ABS1418K8-25	Item 43
1	Screw	ABS1418K8-26	Item 37
	with		
2	Nut	ASNA2531-8	Item 44
	and if necessary		
2	Washer	NSA5372-816AX	
	and/or		
2	Washer	NSA5372-816EX	

	and/or		
2	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		
2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		
2	Washer	NSA5372-716BX	

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (51)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (50)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	

7	Nut	ASNA2536-2	Item 61

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (53)	Retained at removal
1	Duct		Item (52)	Retained at removal

with

1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

(4) Subtask 571131-833-024-002 - Replace the Taperlok with the Next Nominal Diameter Taperlok on the RH Side, ADDITIONAL WORK

Work Zones and Access Panels			
	Zone	Access/Work location	
From	142	Access	Panel 148AZ
		Work location	Rib 1
To	640	Access	Panel 640AB, Panel 640BZ
		Work location	Rib 1

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	5.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Supplementary kit 571131A07S01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	EN6115T2-3	14	BOLT	
61	ASNA2536-2	17	NUT	
62	EN6115T2-2	3	BOLT	
65	NAS1149D0332K	8	WASHER	

Component COMPA04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-7	2	NUT	
34	ABS1418K8-19	4	SCREW	(1)
35	ASNA2532-8	7	NUT	
37	ABS1418K8-26	1	SCREW	(1)
43	ABS1418K8-25	1	SCREW	(1)
44	ASNA2531-8	2	NUIT	
73	ABS1418K9-15	2	SCREW	(1)
74	ABS1418K9-16	8	SCREW	(1)
75	ABS1418K9-17	6	SCREW	(1)
76	ASNA2532-9	16	NUT	
78	ABS1418K8-20	2	SCREW	(1)
80	ABS1418K7-23	2	SCREW	(1)
82	ABS1418K8-22	1	SCREW	(1)
	NSA5372-716AX	2	WASHER	
	NSA5372-716BX	2	WASHER	
	NSA5372-716EX	2	WASHER	
	NSA5372-816AX	9	WASHER	
	NSA5372-816BX	9	WASHER	
	NSA5372-816EX	9	WASHER	
	NSA5372-916AX	16	WASHER	
	NSA5372-916BX	16	WASHER	
	NSA5372-916EX	16	WASHER	

NOTE: The quantities given in the component table are for all the taperloks replacement.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): In accordance with the result of the inspection, you have to order the taperlok to KLX Aerospace.

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required	
	Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required	

Kit tool 571131T02R00				
ITEM	PART N°	KEYWORD	QTY	SEE NOTES
	98D57103002000	Test	1	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Drawing	R57102001
Non Destructive Test Manual (NTM)	51-10-01 PART 6
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00
Fig. A-FCDAA Definition of the Washer Thickness for the New Taperlok	Sheet 01
Fig. A-FDAAA Removal/Installation of the Cooling Duct	Sheet 01
Fig. A-FDBAA Removal/Installation of the Belly Fairing Structure	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCGAB RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00 and SRM 51-43-00

Refer to AMM Task 20-21-11-911-001

Refer to NTM 51-10-01 PART 6

Refer to Fig. A-FCGAB Sheet 01 to Fig. A-FCGAB Sheet 07

(a) Depending on the result of the inspection, remove for access :

1 Remove the cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct	Item (54)	Retain
1	Duct	Item (52)	Retain
	attached with		
1	Clamp	Item (63)	Retain
8	Screw	Item (64)	Retain
8	Washer	Item (65)	Discard

2 Remove the structure of the belly fairing.

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed	Item (171)	Retain
	attached with		
3	Rivet	Item (62)	Discard
7	Rivet	Item (60)	Discard
10	Bush	Item (61)	Discard
	and/or		
1	Web 4 assy	Item (170)	Retain
	attached with		
7	Rivet	Item (60)	Discard
7	Bush	Item (61)	Discard

(b) In accordance with the result of the inspection, remove the taperlok(s) :

Refer to Fig. A-FCGAB Sheet 01 to Fig. A-FCGAB Sheet 04

4	Screw	Item (7)	Discard
1	Screw	Item (14)	Discard
1	Screw	Item (12)	Discard
2	Screw	Item (70)	Discard
8	Screw	Item (71)	Discard
6	Screw	Item (72)	Discard
2	Screw	Item (77)	Discard
2	Screw	Item (79)	Discard
1	Screw	Item (81)	Discard

NOTE: The nuts are removed during the inspection.

(c) Do a rototest inspection of the holes for cracks refer to NTM 51-10-01 PART 6.

1 If cracks are found, contact AIRBUS before any further work.

2 If no crack is found, do the following steps.

(d) Oversize the hole to the next nominal diameter in accordance with the drilling procedure given in the Repair Instruction Drawing R57102001 and use the drilling tool SOA-TL-R57102001B.

NOTE: To prevent any accidental damage, we recommend to train to oversize the taperlok holes on the test specimen.

98D57103002000 Test specimen 1

(e) Depending on the removal, install :

Refer to Fig. A-FCGAB Sheet 01, Fig. A-FCGAB Sheet 02, Fig. A-FCGAB Sheet 05, Fig. A-FCGAB Sheet 06, Fig. A-FCGAB Sheet 07

4	Screw	ABS1418K8-19	Item 34
2	Screw	ABS1418K8-20	Item 78
1	Screw	ABS1418K8-22	Item 82
	with		
7	Nut	ASNA2532-8	Item 35
	and if necessary		

7	Washer	NSA5372-816AX	
	and/or		
7	Washer	NSA5372-816EX	
	and/or		
7	Washer	NSA5372-816BX	
	and		
1	Screw	ABS1418K8-25	Item 43
1	Screw	ABS1418K8-26	Item 37
	with		
2	Nut	ASNA2531-8	Item 44
	and if necessary		
2	Washer	NSA5372-816AX	
	and/or		
2	Washer	NSA5372-816EX	
	and/or		
2	Washer	NSA5372-816BX	
	and		
2	Screw	ABS1418K9-15	Item 73
8	Screw	ABS1418K9-16	Item 74
6	Screw	ABS1418K9-17	Item 75
	with		
16	Nut	ASNA2532-9	Item 76
	and if necessary		
16	Washer	NSA5372-916AX	
	and/or		
16	Washer	NSA5372-916EX	
	and/or		
16	Washer	NSA5372-916BX	
	and		

2	Screw	ABS1418K7-23	Item 80
	with		
2	Nut	ASNA2531-7	Item 11
	and if necessary		
2	Washer	NSA5372-716AX	
	and/or		
2	Washer	NSA5372-716EX	
	and/or		
2	Washer	NSA5372-716BX	

NOTE: Install the screw in accordance with the installation principle given in the repair instruction R57102001.

NOTE: If necessary, install the washer in accordance with the definition of the washer thickness given in the Fig. A-FCDAA Sheet 01.

NOTE: Wet assembly, apply :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required

NOTE: Torque the nuts between 5.60 daN and 6.70 daN (493 lbf.in. and 592 lbf.in.).

NOTE: Outside the wing center box, apply on the screws :

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

NOTE: Inside the wing center box, apply on the nuts :

Polysulfide Sealant-Fuel Tank Fillet	06ABB1	As required
Adhesion Promoter-For Polysulfide Sealant	06PAG1	As required

(f) If removed, install :

1 The structure of the belly fairing

Refer to Fig. A-FDBAA Sheet 01 to Fig. A-FDBAA Sheet 03

1	Channel-Formed		Item (171)	Retained at removal
	with			
7	Bolt	EN6115T2-3	Item 60	
3	Bolt	EN6115T2-2	Item 62	
10	Nut	ASNA2536-2	Item 61	
	and/or			
1	Web 4 assy		Item (170)	Retained at removal
	attached with			
7	Bolt	EN6115T2-3	Item 60	
7	Nut	ASNA2536-2	Item 61	

NOTE: Apply to the interface of the structure and all the parts :

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 The cooling duct.

Refer to Fig. A-FDAAA Sheet 01

1	Duct		Item (54)	Retained at removal
1	Duct		Item (52)	Retained at removal
	with			
1	Clamp		Item (63)	Retained at removal
8	Screw		Item (64)	Retained at removal
8	Washer	NAS1149D0332K	Item 65	

**CONF ALL

D. TEST

**CONF 001

(1) Subtask 571131-710-003-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-720-005 Task 20-28-00-869-002 Task 28-11-00-280-002 Task 28-21-00-710-006 Task 57-17-11-400-001 Task 57-27-11-400-001

(a) Job Set-up :

1 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(b) Test :

1 Do the test procedure as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Do the test procedure as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

3 Do a fuel tanks leak checks (only leak test of the center tank or/and leak test of the wing tanks - without fuel - by the local blowing procedure), refer to AMM Task 28-11-00-280-002.

NOTE: Do this test on the taperlok bolts inspected by this Service Bulletin.

4 For all the access panels and covers removed during the preparation procedure, do a check of the electrical bonding (external metal surfaces/parts (hinges or fixed)) refer to AMM Task 20-28-00-720-005.

NOTE: For the maximum permitted resistance values : refer to the table AMM Task 20-28-00-869-002.

**CONF 002

(1) Subtask 571131-710-003-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-720-005 Task 20-28-00-869-002 Task 28-11-00-280-002 Task 28-21-00-710-006 Task 57-17-11-400-001 Task 57-27-11-400-001

(a) Job Set-up :

1 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Remove the safety clips and/or tags and close/unlock the circuit breakers as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(b) Test :

1 Do the test procedure as specified after the installation of the access covers 147AZ and 148AZ, refer to AMM Task 57-17-11-400-001.

2 Do the test procedure as specified after the installation of the access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

3 Do a fuel tanks leak checks (only leak test of the center tank or/and leak test of the wing tanks - without fuel - by the local blowing procedure), refer to AMM Task 28-11-00-280-002.

NOTE: Do this test on the taperlok bolts inspected by this Service Bulletin.

4 For all the access panels and covers removed during the preparation procedure, do a check of the electrical bonding (external metal surfaces/parts (hinges or fixed)) refer to AMM Task 20-28-00-720-005.

NOTE: For the maximum permitted resistance values : refer to the table AMM Task 20-28-00-869-002.

**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 571131-410-005-001 - Install/Close Items Removed/Opened for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 540BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 540AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 147AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(2) Subtask 571131-410-006-001 - Install/Close Items Removed/Opened for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001

References	
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 640BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 640AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 148AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels , 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(3) Subtask 571131-942-003-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	28-25-00, Page Block 301 Task 32-12-00-410-001

(a) Refuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

(b) Refuel the center tank, refer to AMM 28-25-00 Page Block 301.

(c) Close the main landing gear doors, refer to AMM Task 32-12-00-410-001.

(d) Remove the access platform(s).

(e) Put the aircraft back to its initial configuration.

****CONF 002**

(1) Subtask 571131-410-005-001 - Install/Close Items Removed/Opened for Access on the LH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 6QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 540BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 540AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 147AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels 191LB and 147CB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(2) Subtask 571131-410-006-001 - Install/Close Items Removed/Opened for Access on the RH Side

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 28-21-42-400-001 Task 28-21-54-400-001 Task 53-35-11-400-001 Task 57-17-11-400-001 Task 57-27-11-400-001 Task 57-27-12-400-001
Fig. A-FDCAA Removal/Installation of the Fuel Pump Strainer Covers	Sheet 01

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Install the covers Item (80) and (81) of the fuel pump strainer FIN 8QM, refer to Fig. A-FDCAA Sheet 01 and AMM Task 28-21-54-400-001.

(c) Install the fuel pump suction valve, refer to AMM Task 28-21-42-400-001.

(d) Close the fuel surge access door 640BZ, refer to AMM Task 57-27-12-400-001.

(e) Install the wing access panel 640AB, refer to AMM Task 57-27-11-400-001.

(f) Install the access cover 148AZ, refer to AMM Task 57-17-11-400-001.

(g) If removed, install the panels , 192LB and 148DB on the wing to fuselage, refer to AMM Task 53-35-11-400-001.

(3) Subtask 571131-942-003-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	28-25-00, Page Block 301 Task 32-12-00-410-001

(a) Refuel the LH and RH wing tanks, refer to AMM 28-25-00 Page Block 301.

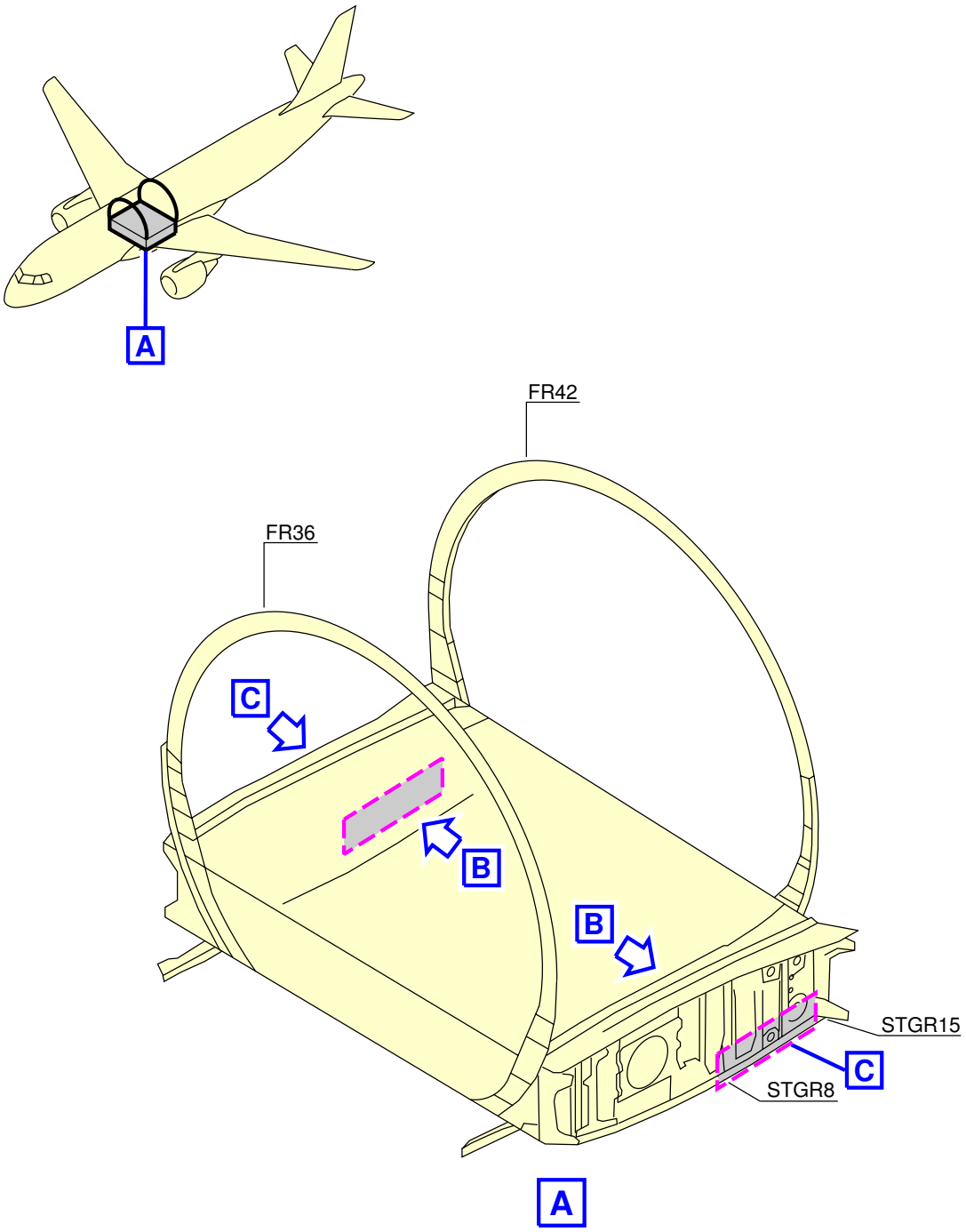
(b) Refuel the center tank, refer to AMM 28-25-00 Page Block 301.

(c) Close the main landing gear doors, refer to AMM Task 32-12-00-410-001.

(d) Remove the access platform(s).

(e) Put the aircraft back to its initial configuration.

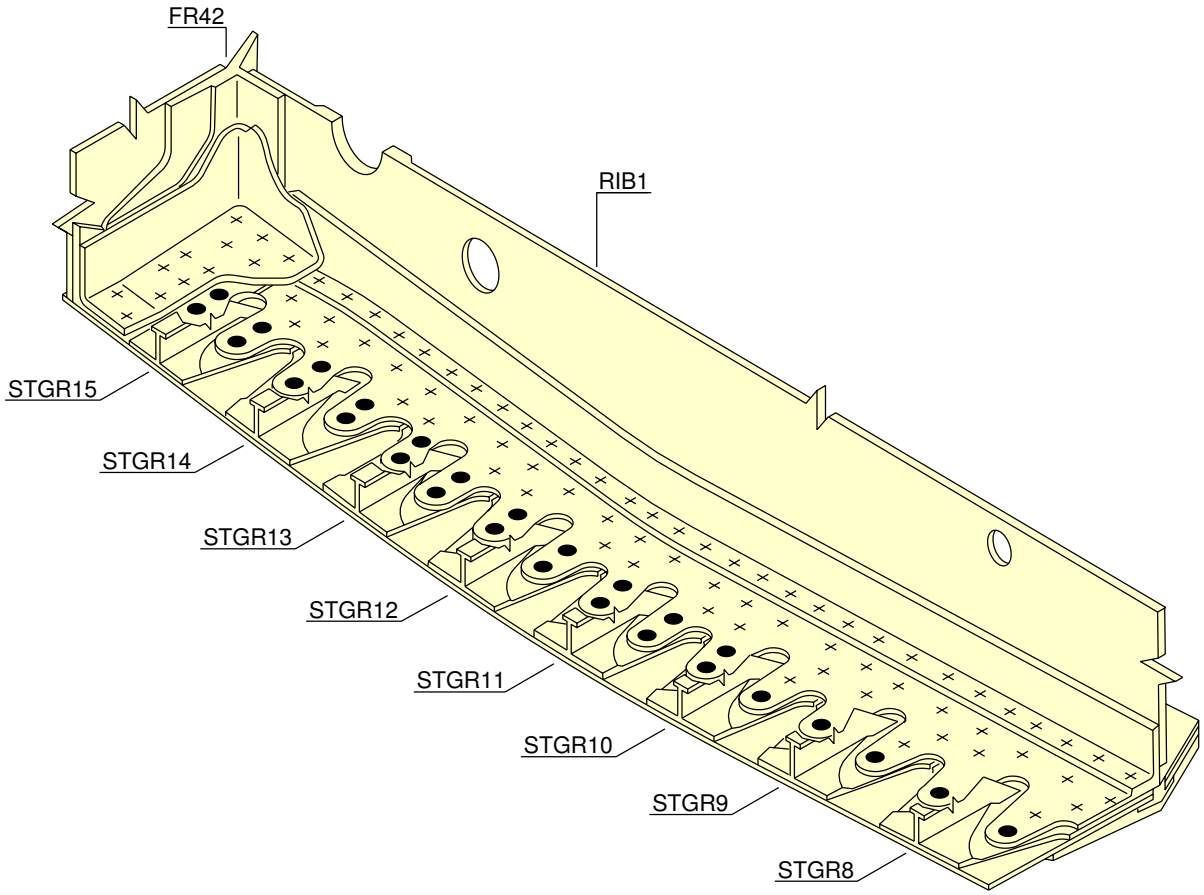
**CONF ALL

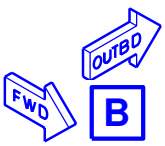


N_SB_571131_5_BAAA_01_02

Figure A-FBAAA - Sheet 01
Inspection of the Fasteners

****CONF ALL**





VIEW LOOKING DOWN
LH SHOWN
RH SYMMETRICAL

NOTE:

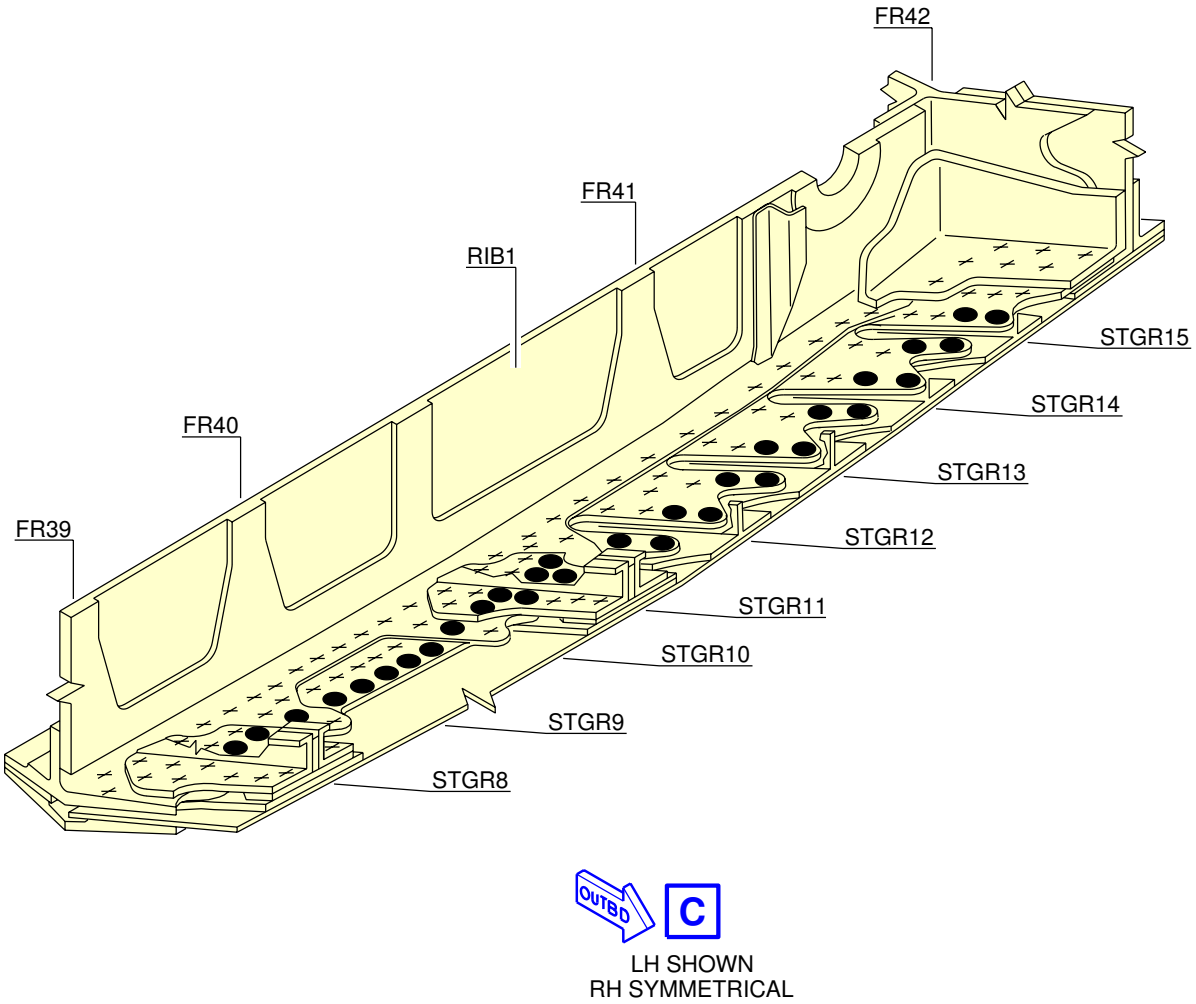
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_BAAA_02_01

Figure A-FBAAA - Sheet 02
Inspection of the Fasteners

**CONF ALL



NOTE:

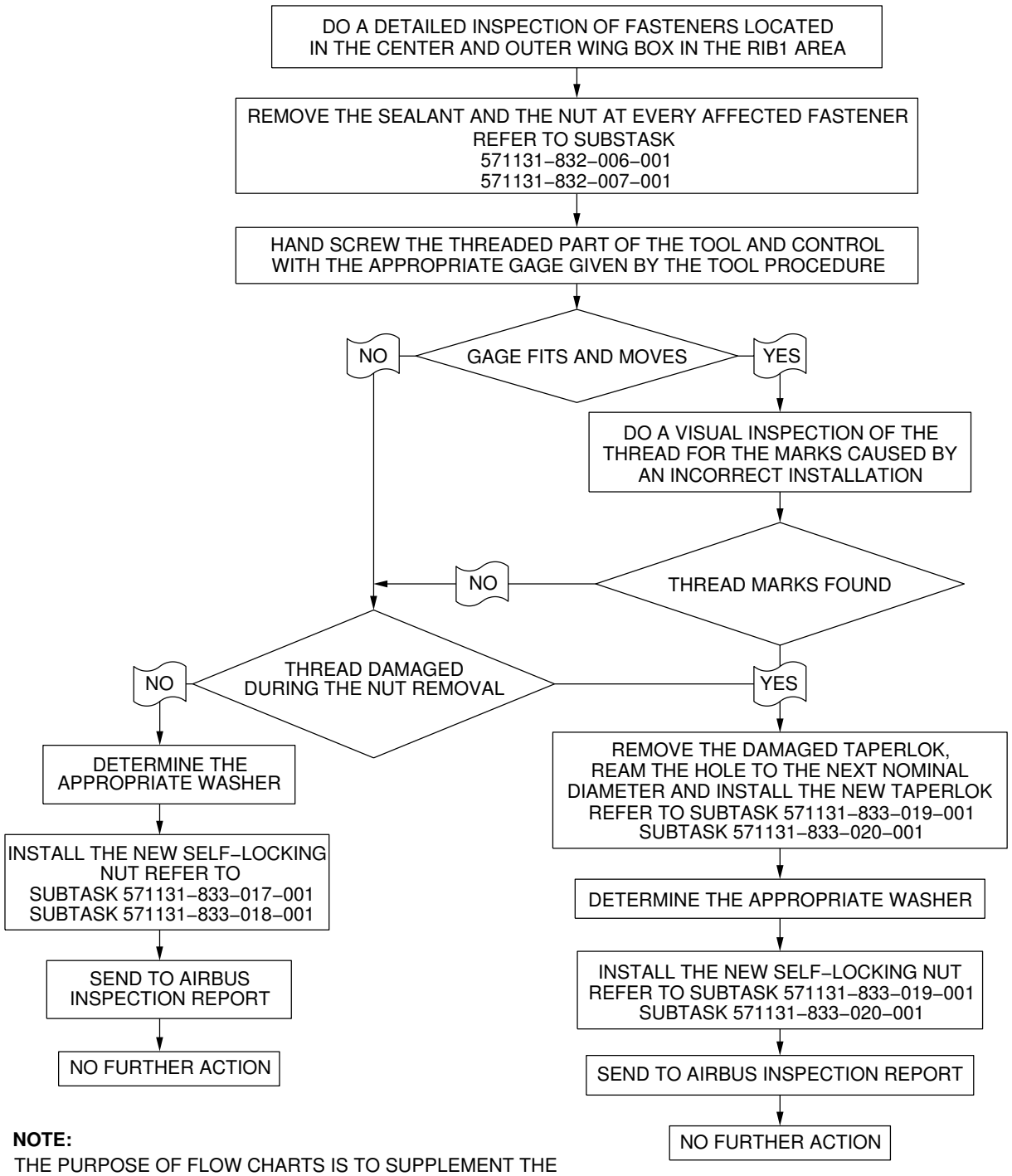
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_BAAA_03_01

Figure A-FBAAA - Sheet 03
Inspection of the Fasteners

****CONF ALL**



NOTE:

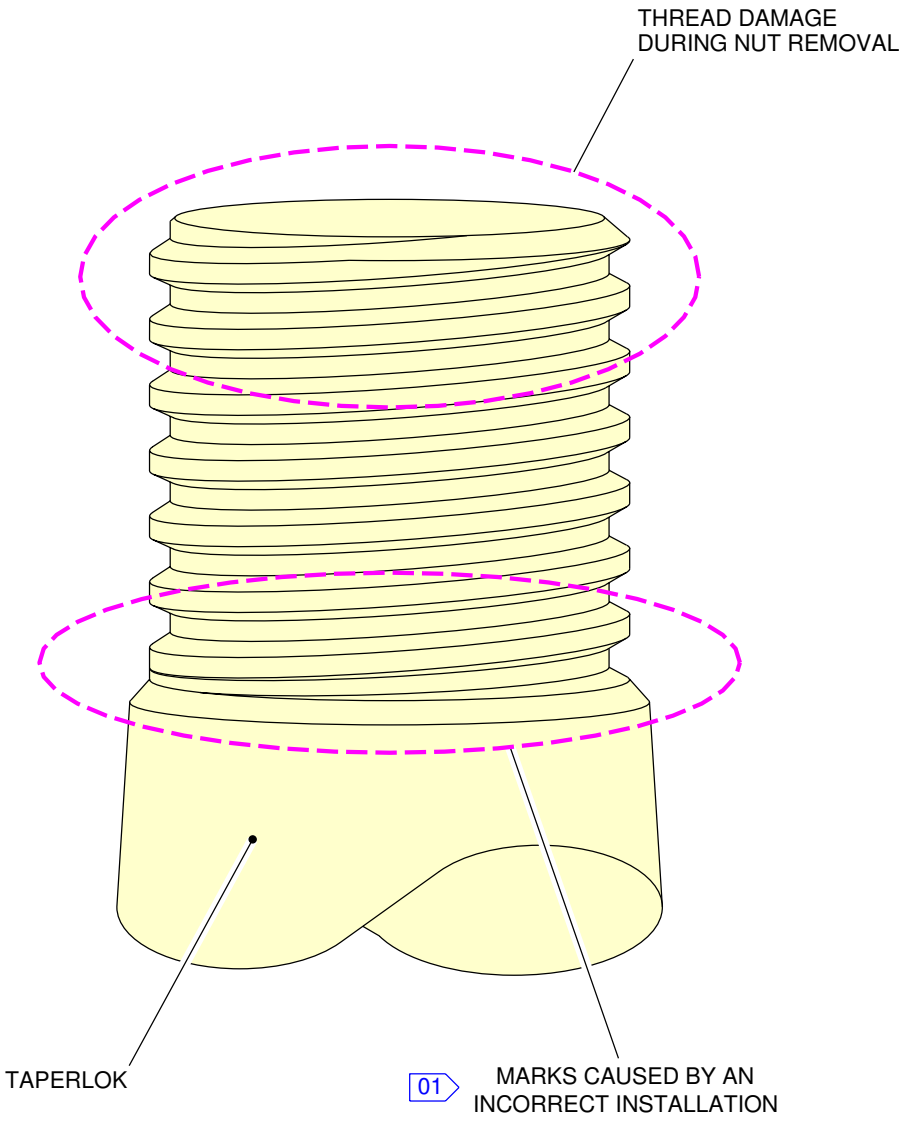
THE PURPOSE OF FLOW CHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

N_SB_571131_5_FAAA_01_04

Figure A-FFAAA - Sheet 01
Flow Chart

**CONF ALL

THREAD DAMAGE



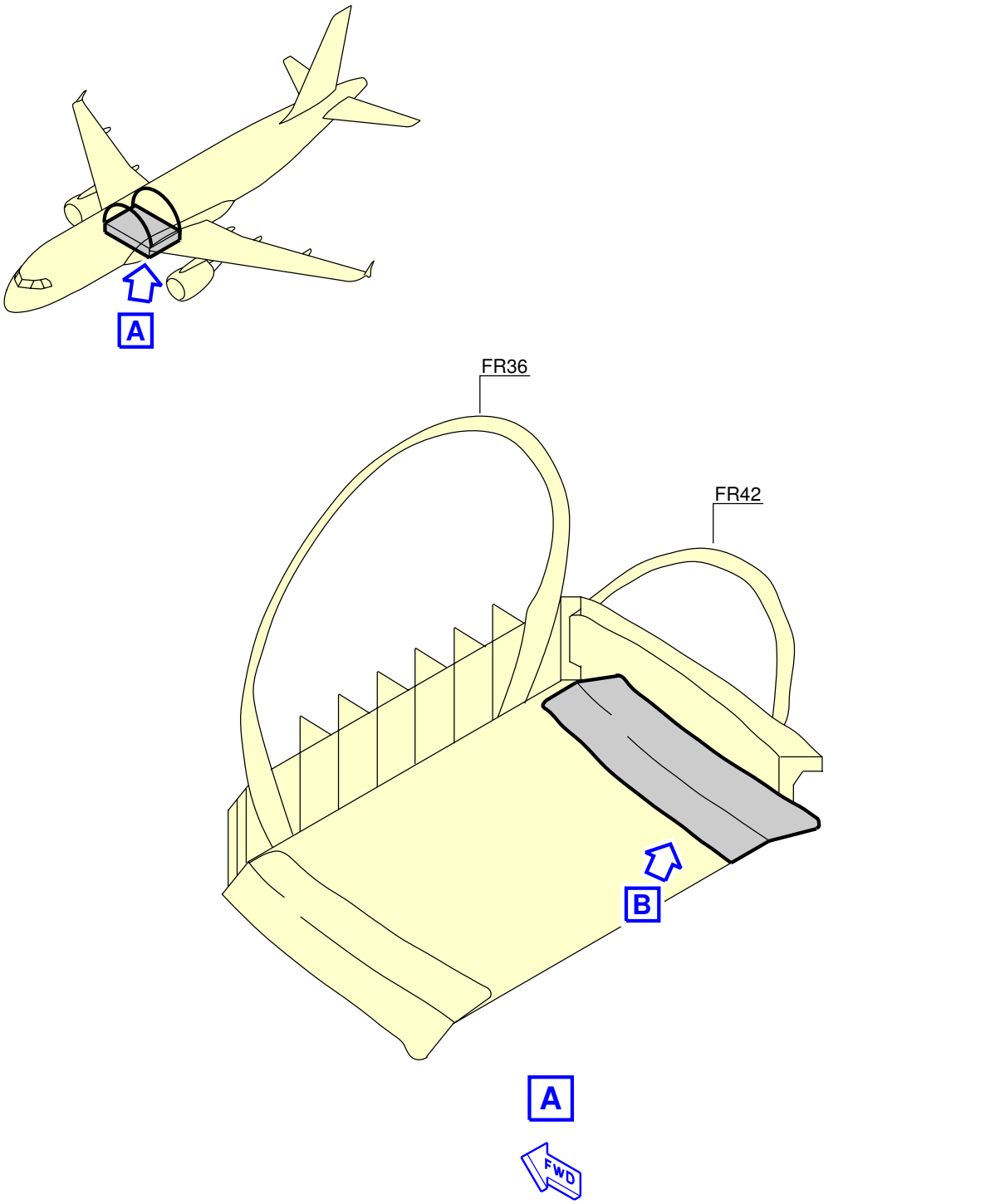
NOTE:

01 FOR MORE INFORMATION OF THE CRITERION MARKS REFER TO THE BOOKLET 06–0009

N_SB_571131_5_BCAA_01_02

Figure A-FBCAA - Sheet 01
Thread Damage

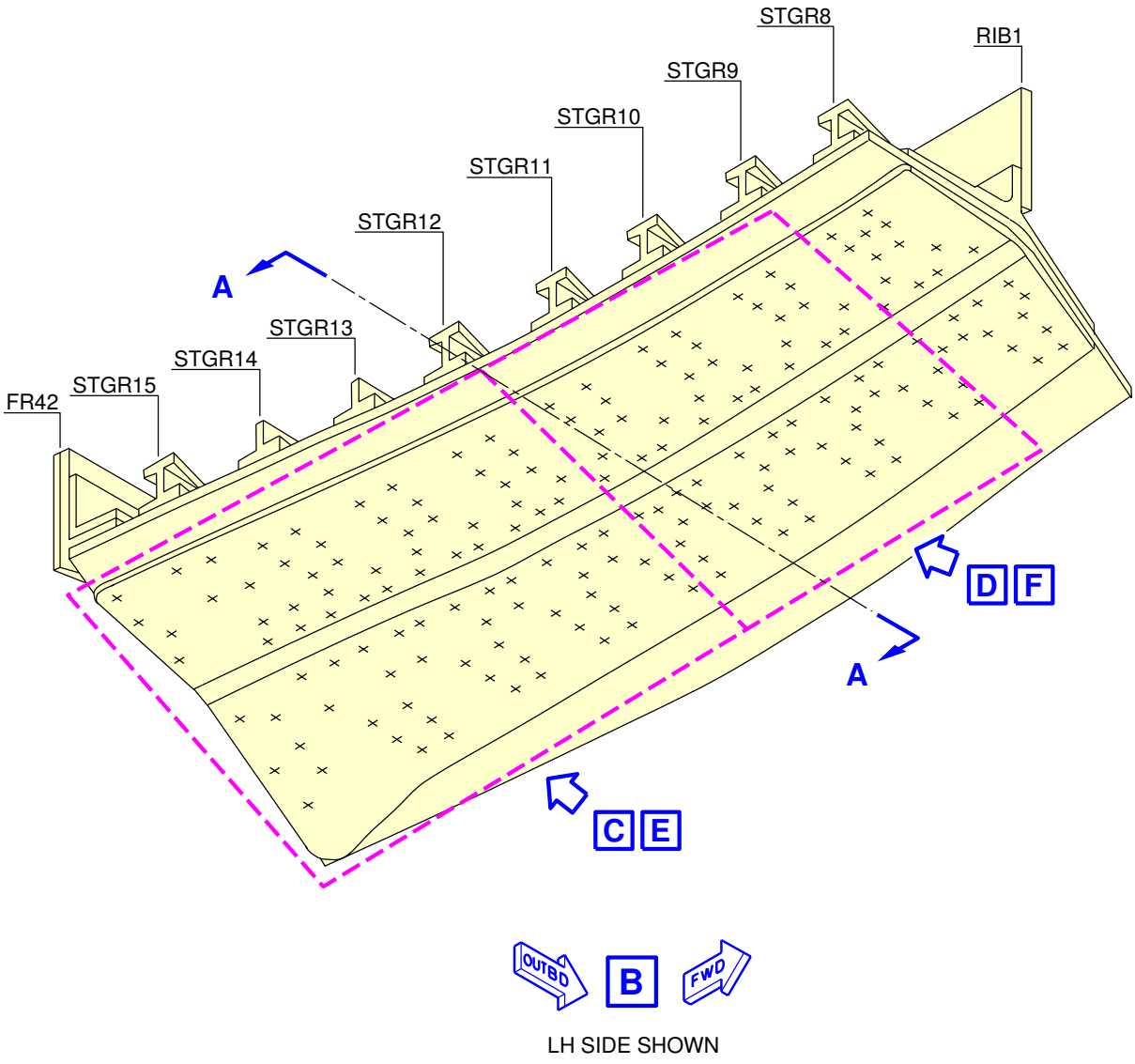
**CONF ALL



N_SB_571131_5_CAAA_01_01

Figure A-FCAAA - Sheet 01
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL

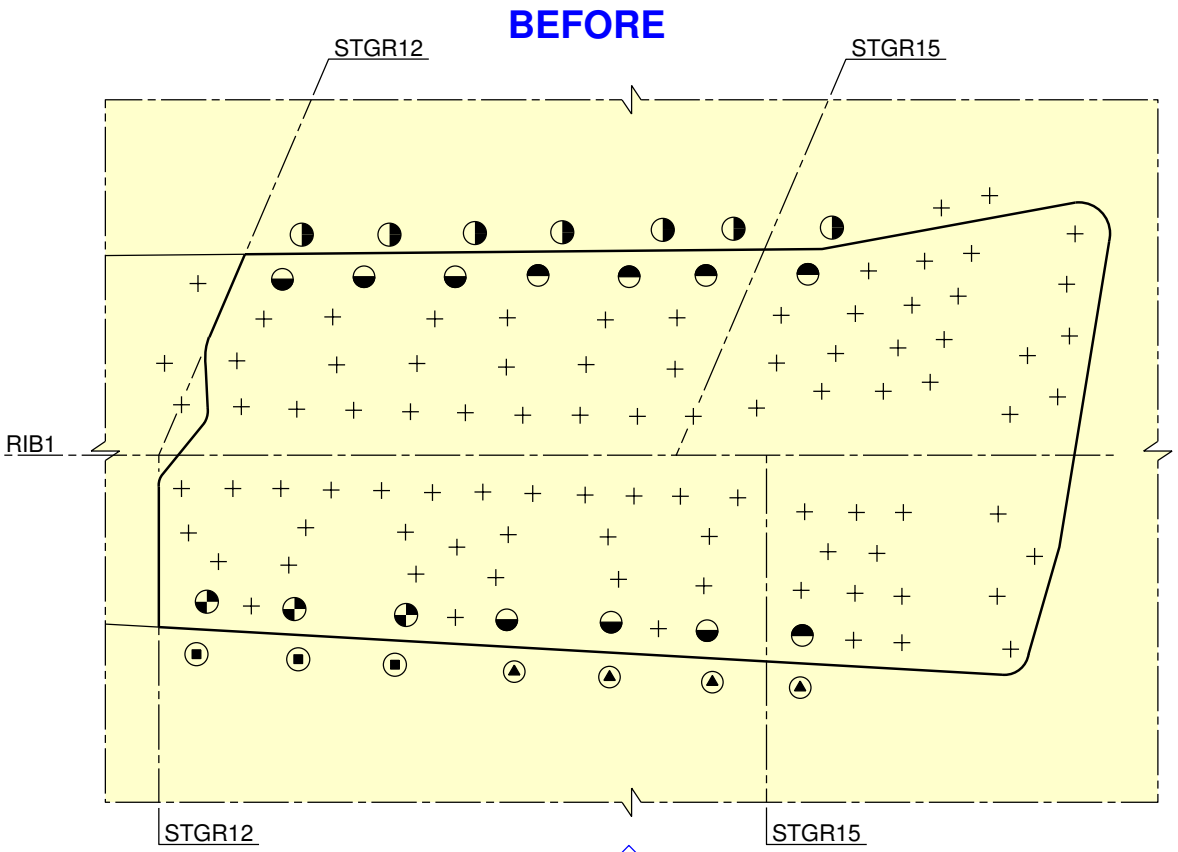


LH SIDE SHOWN

N_SB_571131_5_CAAA_02_00

Figure A-FCAAA - Sheet 02
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



NOTE:

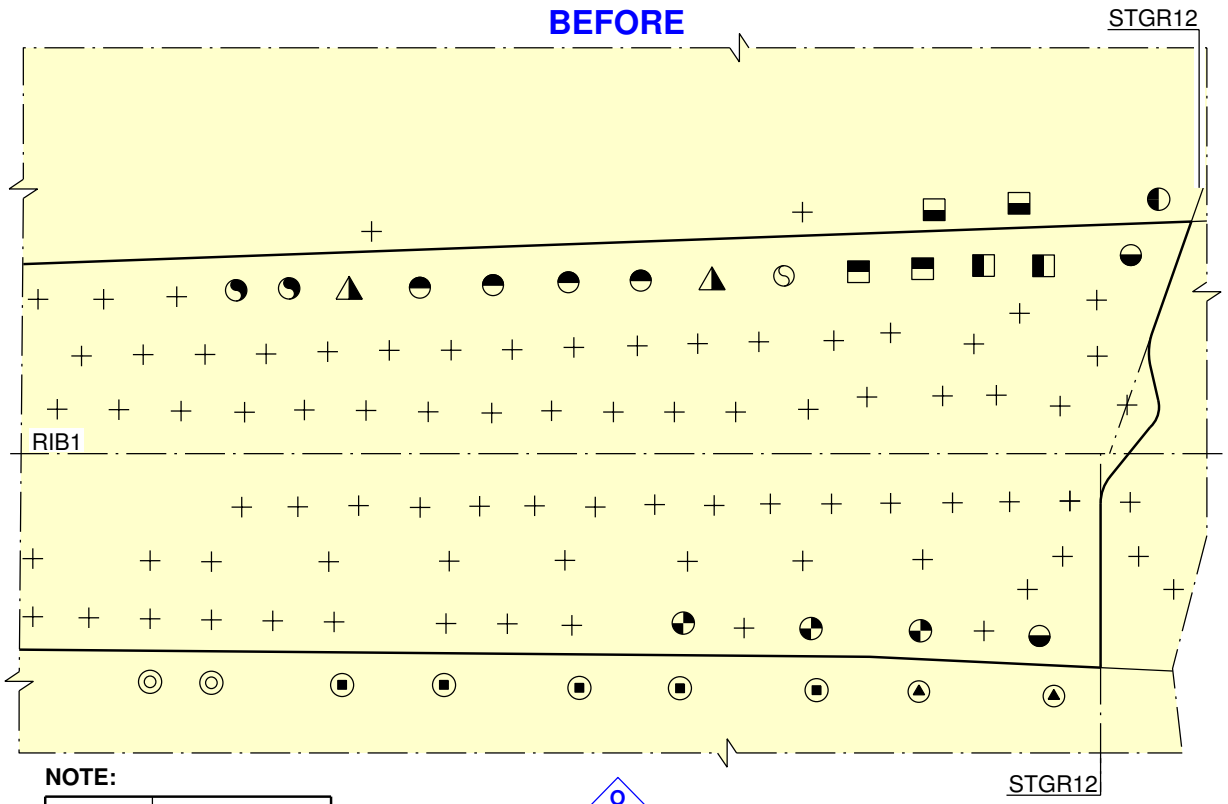
HOLE	OLD ITEM
◒	(10) OR (5) (10)
◕	(10) OR (16) (10)
◓	(10) OR (7) (10)
◑	(10) OR (3) (10)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CAAA_03_01

Figure A-FCAAA - Sheet 03
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



NOTE:

HOLE	OLD ITEM
◒	(10) OR (5) (10)
◔	(10) OR (16) (10)
◐	(10) OR (1) (10)
◧	(11) OR (14) (11)
⬓	(11) OR (5) (11)
⬒	(11) OR (12) (11)
◭	(13) OR (72) (13)
▣	(13) OR (71) (13)

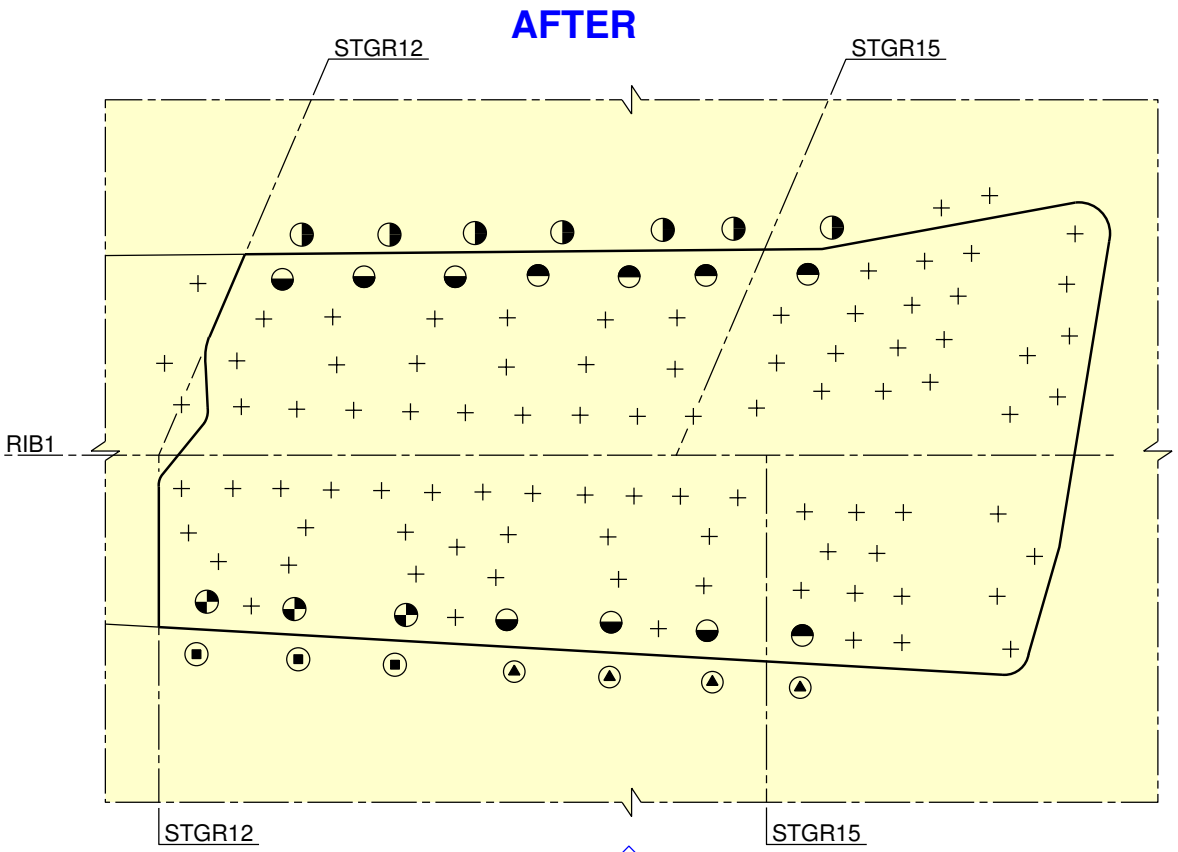
◎	(13) OR (70) (13)
◭	(10) OR (77) (10)
◒	(10) OR (7) (10)
⦸	(10) OR (81) (10)
◕	(15) OR (79) (15)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CAAA_04_02

Figure A-FCAAA - Sheet 04
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



HOLE	OLD ITEM
◒	10 OR 33 35
◕	10 OR 38 35
◓	10 OR 34 35
◑	10 OR 32 35
▲	13 OR 75 76
■	13 OR 74 76

┼ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA.

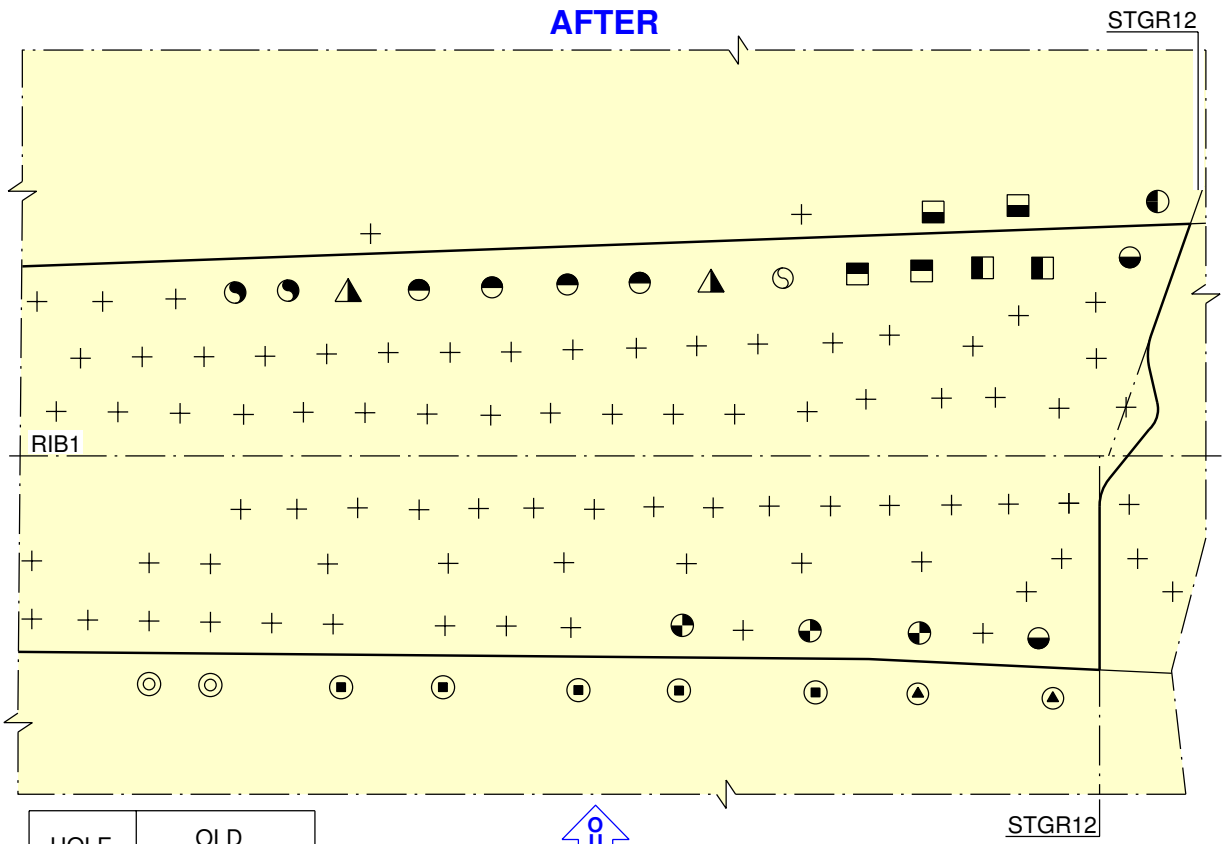
IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in).

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in).

N_SB_571131_5_CAAA_05_01

Figure A-FCAAA - Sheet 05
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



HOLE	OLD ITEM
◒	10 OR 33 35
◕	10 OR 38 35
◐	10 OR 31 35
◧	11 OR 37 44
⬓	11 OR 36 44
⬒	11 OR 43 44
◭	13 OR 75 76
▣	13 OR 74 76

◎	13 OR 73 76
◮	10 OR 78 35

◒	10 OR 34 35
◵	10 OR 82 35
◔	15 OR 80 11

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA.

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in).

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in).

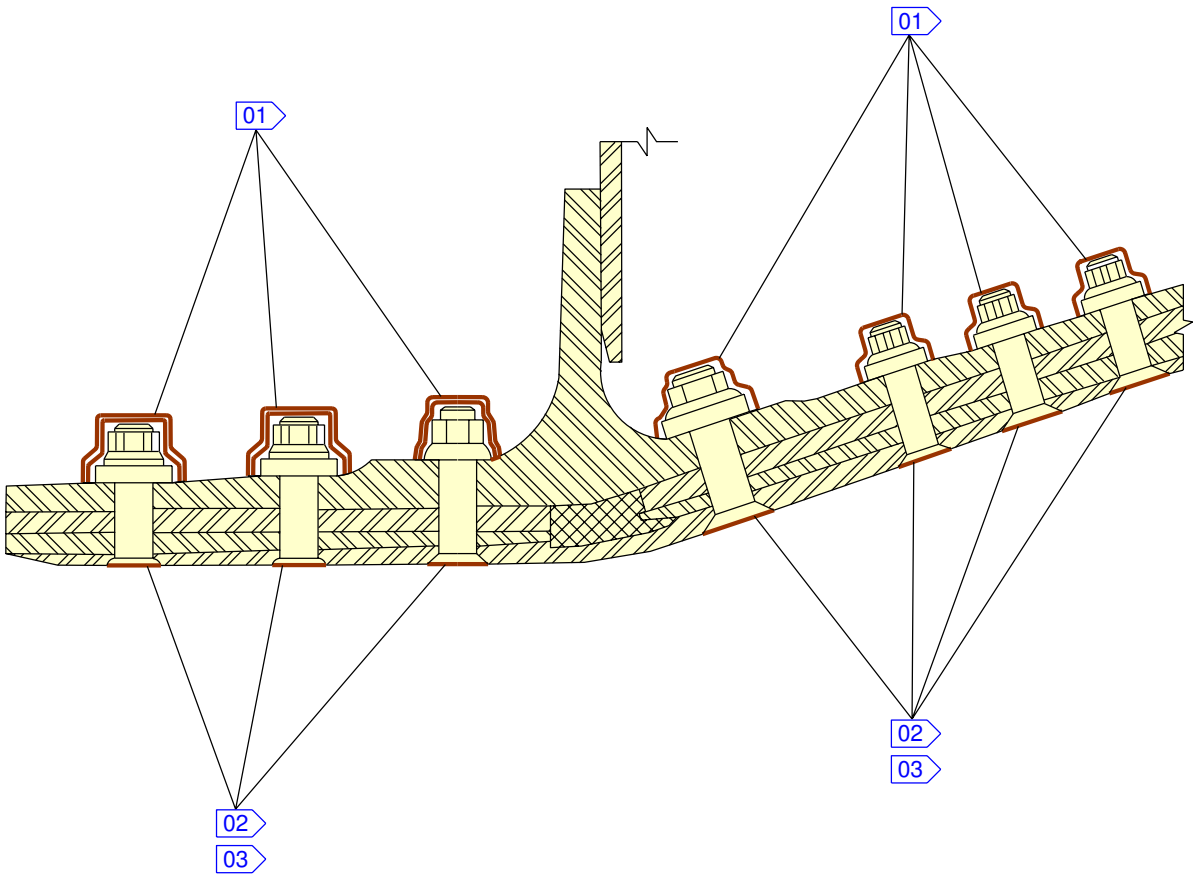
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CAAA_06_01

Figure A-FCAAA - Sheet 06
LH Side, Replacement of the Lower Panel Fasteners

**CONF ALL

SEALING PRINCIPLE



A - A

NOTE:

01 APPLY MAT. No 06ABB1 AND MAT. No 06PAG1 ON THE NUTS

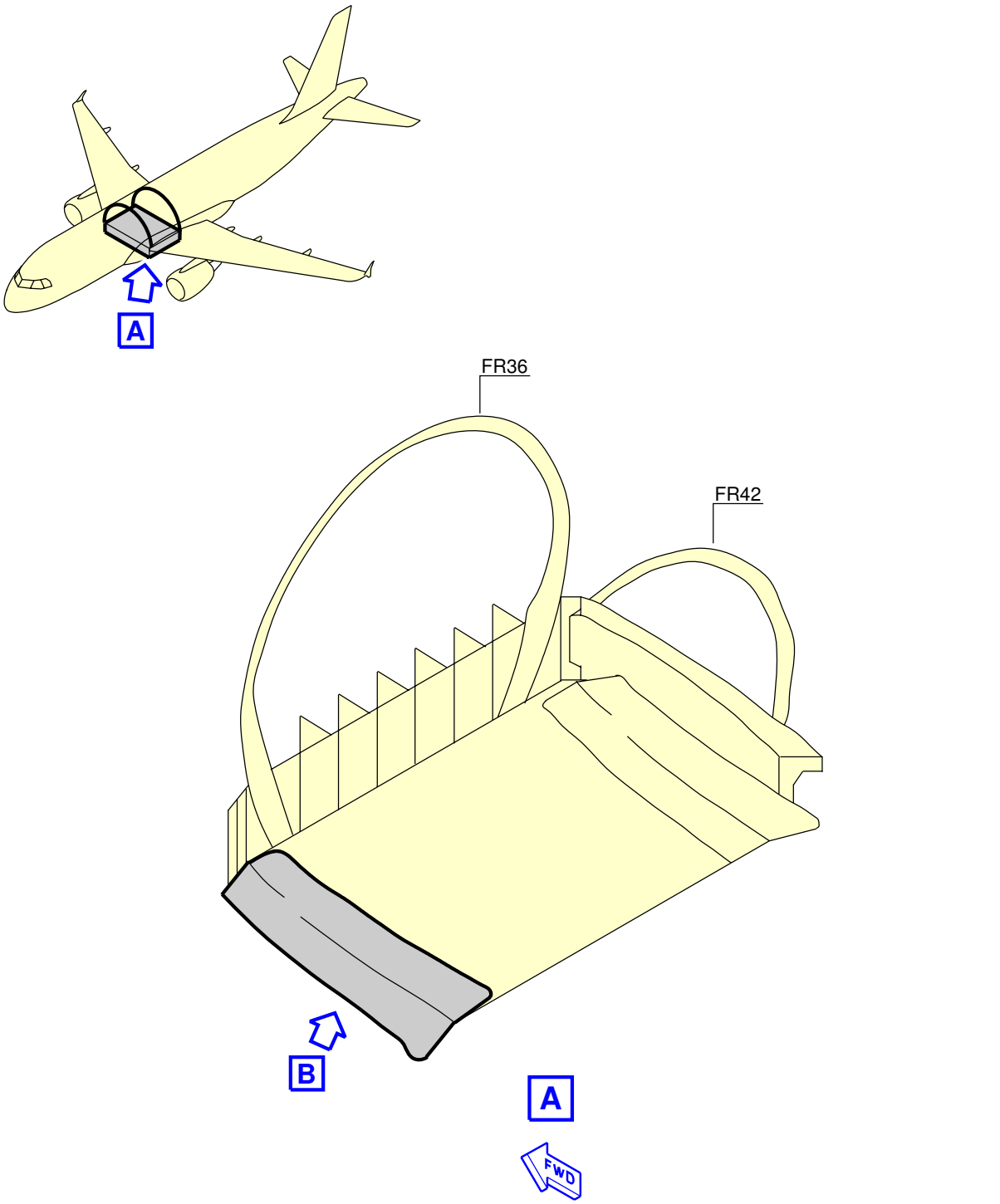
02 APPLY MAT. No 04EAC2, MAT. No 04CMA2 AND MAT. No 04JAA3 ON THE BOLTS

03 WET ASSEMBLY, APPLY MAT. No 06ABB1

N_SB_571131_5_CAAA_07_03

Figure A-FCAAA - Sheet 07
LH Side, Replacement of the Lower Panel Fasteners

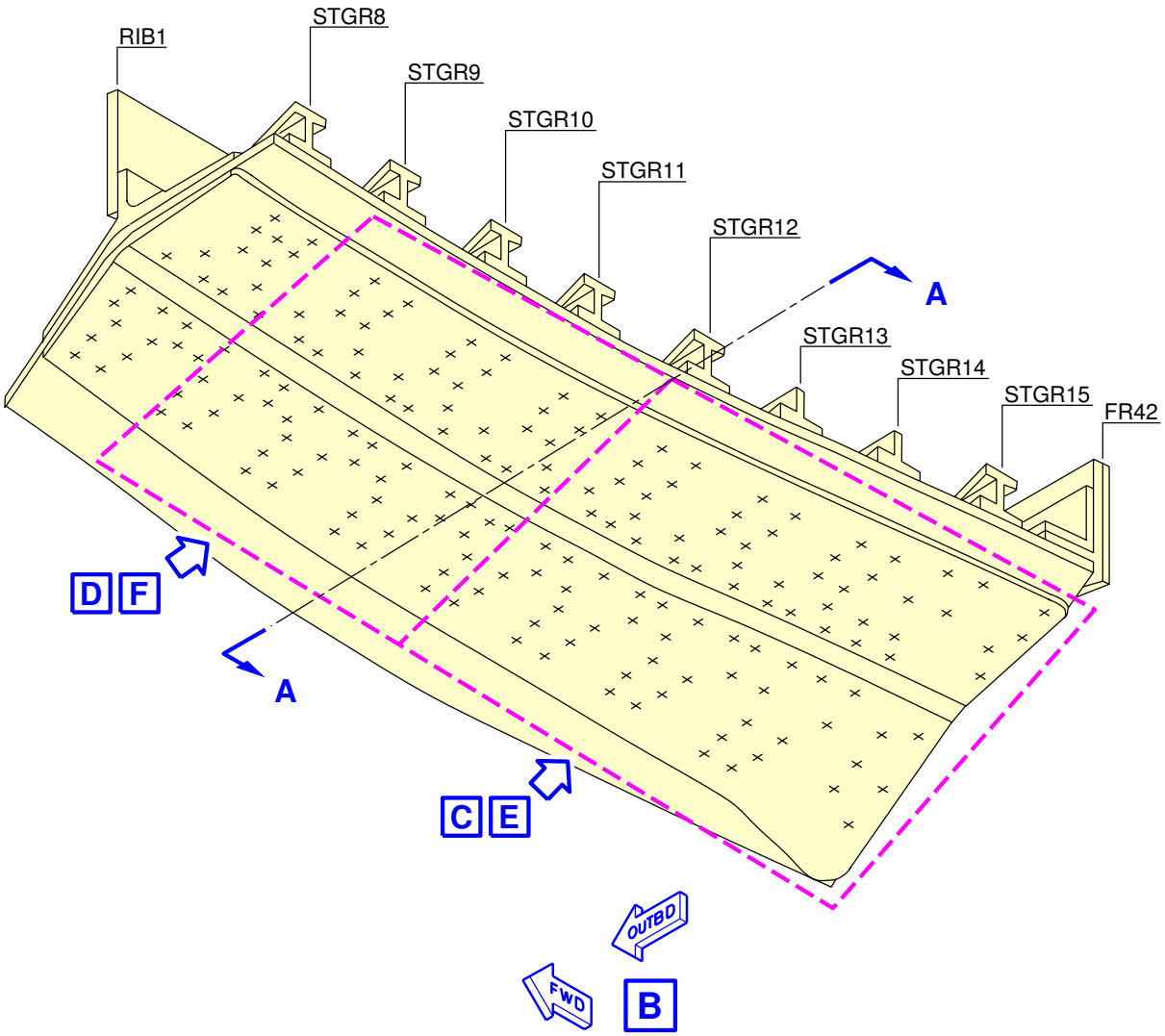
**CONF ALL



N_SB_571131_5_CBAA_01_01

Figure A-FCBAA - Sheet 01
RH Side, Replacement of the Lower Panel Fasteners

**CONF ALL

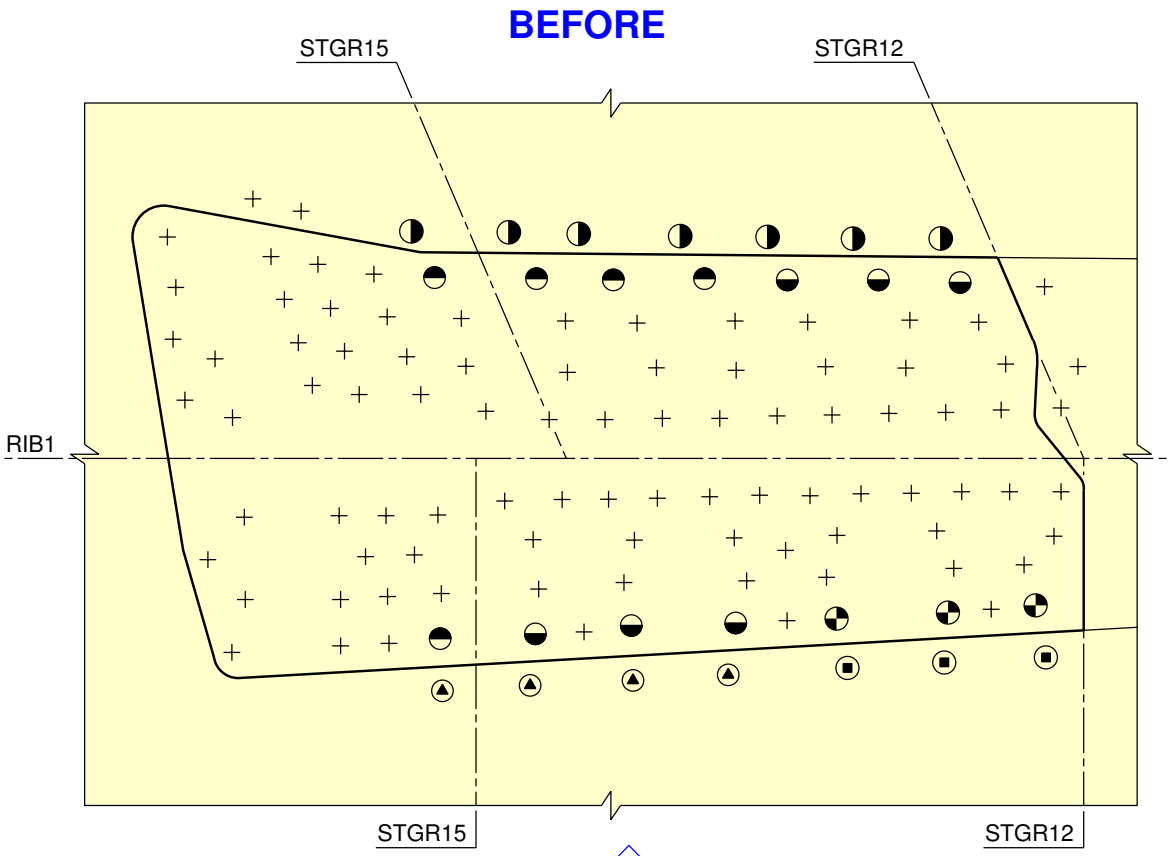


RH SIDE SHOWN

N_SB_571131_5_CBAA_02_00

Figure A-FCBAA - Sheet 02
RH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



NOTE:

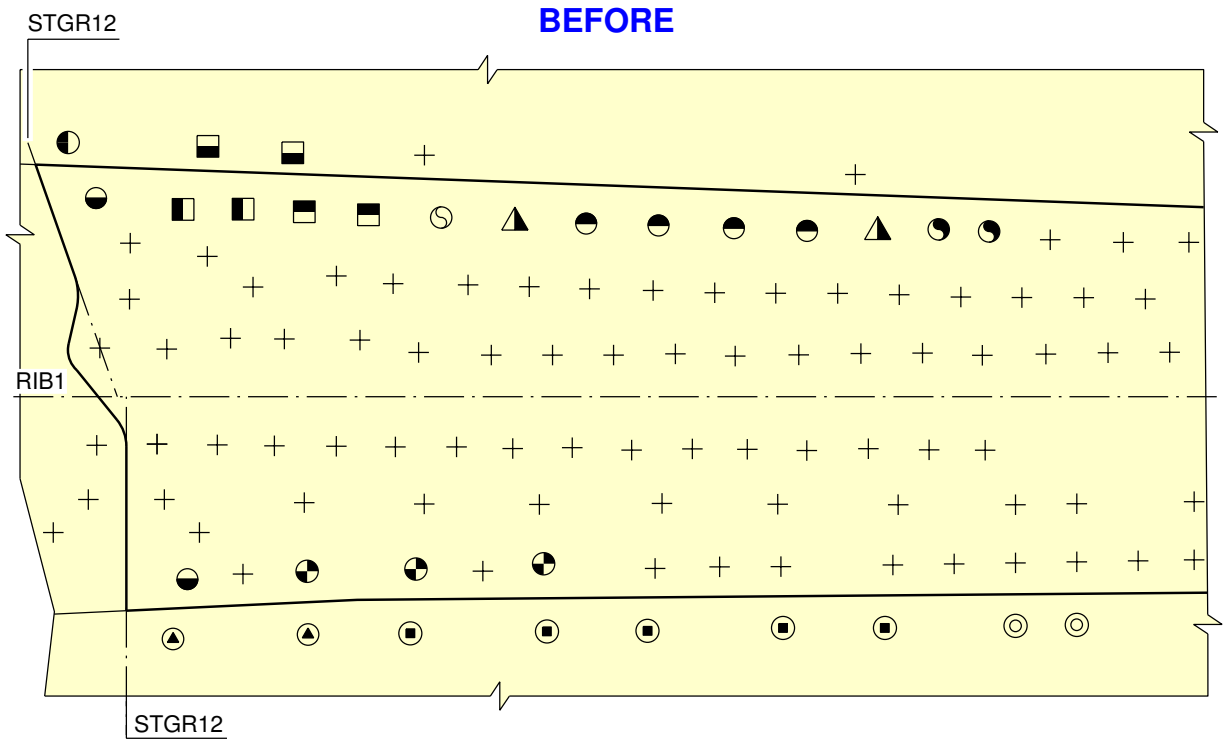
HOLE	OLD ITEM
◒	(10) OR (5) (10)
◕	(10) OR (16) (10)
◓	(10) OR (7) (10)
◑	(10) OR (3) (10)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CBAA_03_02

Figure A-FCBAA - Sheet 03
RH Side, Replacement of the Lower Panel Fasteners

****CONF ALL**



NOTE:

HOLE	OLD ITEM
◒	(10) OR (5) (10)
◔	(10) OR (16) (10)
◐	(10) OR (1) (10)
◧	(11) OR (14) (11)
⬓	(11) OR (5) (11)
⬒	(11) OR (12) (11)
▲	(13) OR (72) (13)
▣	(13) OR (71) (13)

◎	(13) OR (70) (13)
◭	(10) OR (77) (10)
◓	(10) OR (7) (10)
◵	(10) OR (81) (10)
◕	(15) OR (79) (15)

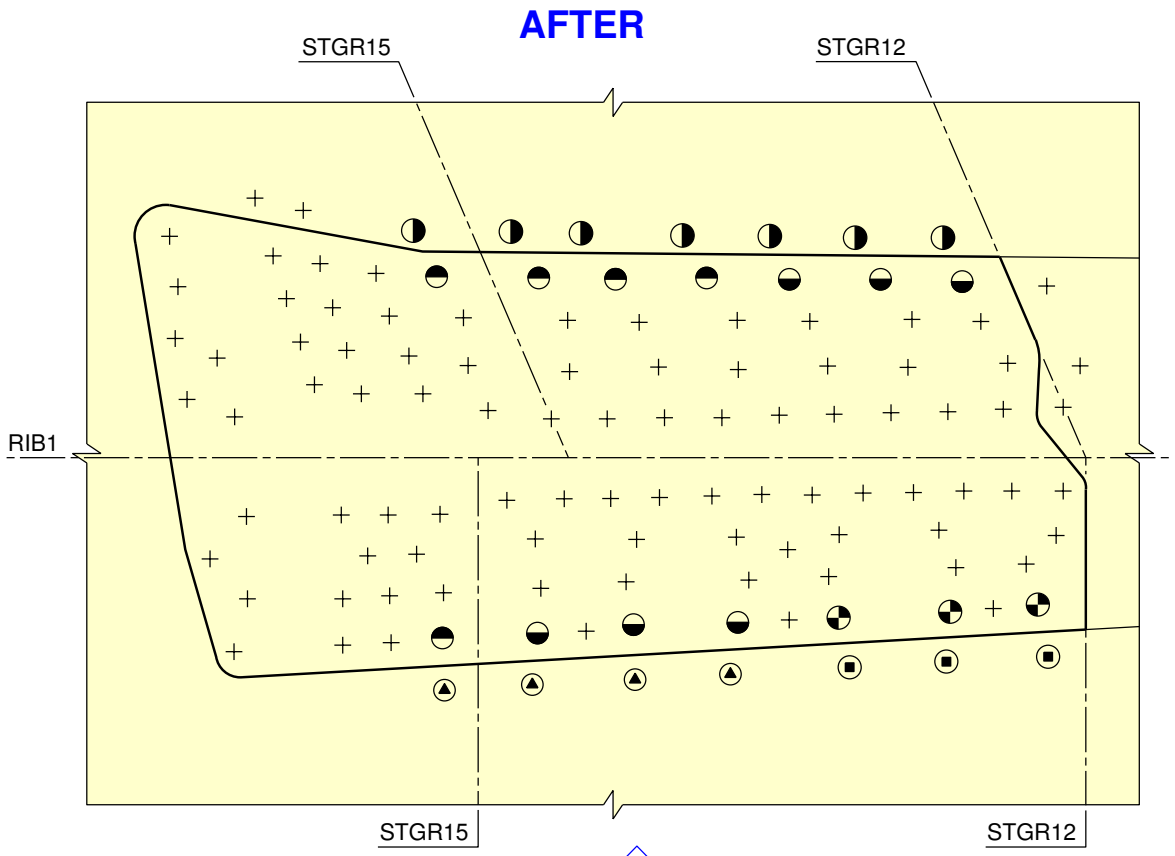
OUTBD
FWD
D
RH
ROTATED VIEW FOR A BETTER UNDERSTANDING

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CBAA_04_03

Figure A-FCBAA - Sheet 04
RH Side, Replacement of the Lower Panel Fasteners

**CONF ALL



HOLE	OLD ITEM
◒	10 OR 33 35
◕	10 OR 38 35
◓	10 OR 34 35
◑	10 OR 32 35
▲	13 OR 75 76
■	13 OR 74 76

┼ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

N_SB_571131_5_CBAA_05_02

Figure A-FCBAA - Sheet 05
RH Side, Replacement of the Lower Panel Fasteners

****CONF ALL**

AFTER

HOLE	OLD ITEM
◒	10 OR 33 35
◕	10 OR 38 35
◐	10 OR 31 35
◧	11 OR 37 44
⬓	11 OR 36 44
⬒	11 OR 43 44
▲	13 OR 75 76
▣	13 OR 74 76

OUTBD

FWD F

RH

ROTATED VIEW FOR A BETTER UNDERSTANDING

◎	13 OR 73 76
◭	10 OR 78 35

◒	10 OR 34 35
◵	10 OR 82 35
◔	15 OR 80 11

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

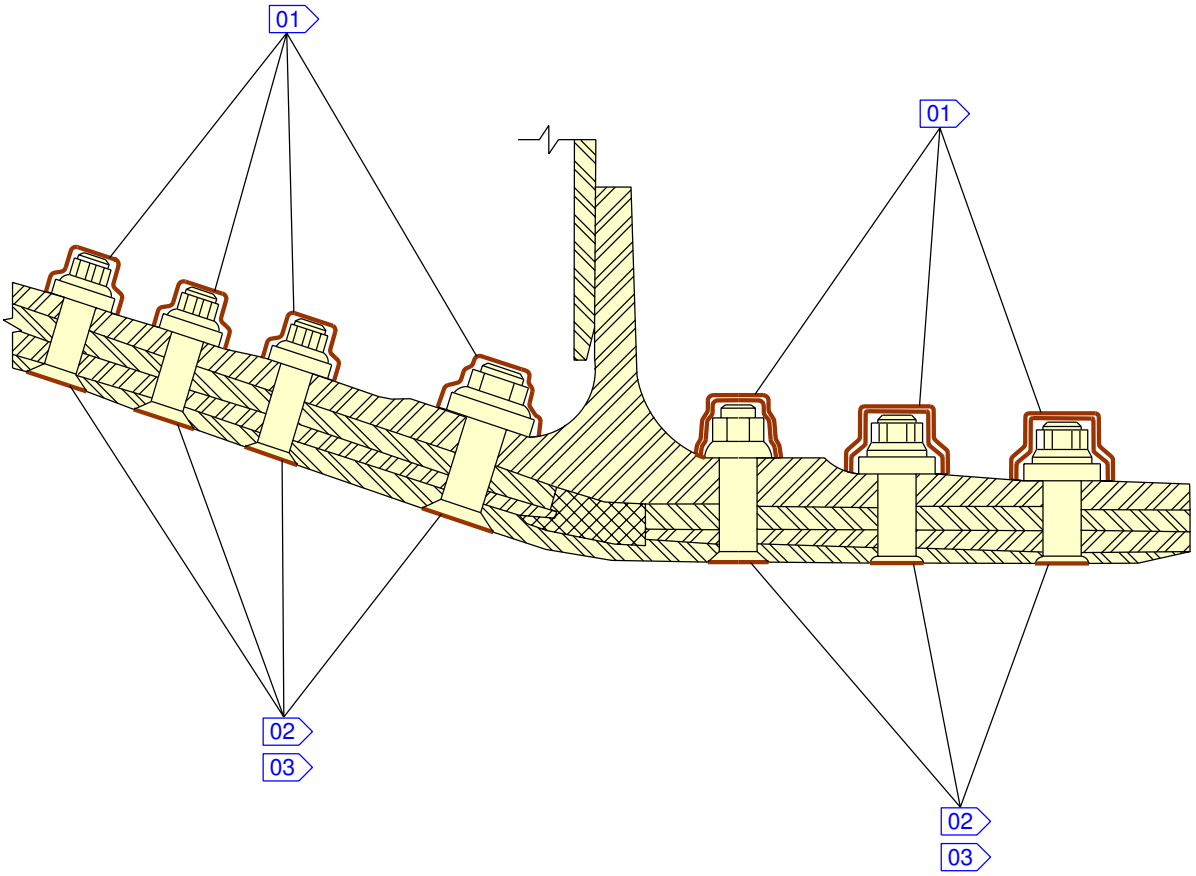
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CBAA_06_02

Figure A-FCBAA - Sheet 06
RH Side, Replacement of the Lower Panel Fasteners

**CONF ALL

SEALING PRINCIPLE



A-A

NOTE:

01 APPLY MAT. No 06ABB1 AND MAT. No 06PAG1 ON THE NUTS

02 APPLY MAT. No 04EAC2, MAT. No 04CMA2 AND MAT. No 04JAA3 ON THE BOLTS

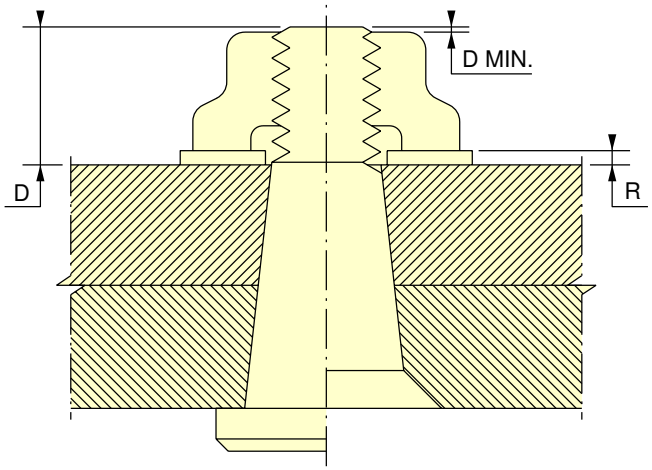
03 WET ASSEMBLY, APPLY MAT. No 06ABB1

N_SB_571131_5_CBAA_07_02

Figure A-FCBAA - Sheet 07
RH Side, Replacement of the Lower Panel Fasteners

**CONF ALL

DEFINITION OF THE WASHER THICKNESS
FOR THE ORIGINAL TAPERLOK



NOTE:

D : TAPERLOK LENGTH PROTRUDING BEYOND THE PLATE

D MIN. : THREADS BEYOND THE NUT (CHAMFER INCLUDED)

R : THICKNESS OF WASHER REQUIRED

N_SB_571131_5_CCAA_01_02

Figure A-FCCAA - Sheet 01
Definition of the Washer Thickness for the Original Taperlok

**CONF ALL

DIAMETER CODE No.	D MIN.	D		R		WASHERS THICKNESSES CODES	EXAMPLES
		mm	in	mm	in		
6	1.02 mm (0.040 in)	⩽ 11.4	0.449	0.8	0.031	A	IF "D" ⩽ 14.2 mm INSTALL THE WASHERS NSA5372–616EX + NSA5372–616CX
		⩽ 11.8	0465	1.2	0.047	E	
		⩽ 12.2	0480	1.6	0.063	B	
		⩽ 12.6	0.496	2	0.079	A+E	
		⩽ 13	0.512	2.4	0.094	C	
		⩽ 13.4	0.528	2.8	0.110	E+B	
		⩽ 13.8	0.543	3.2	0.126	D	
		⩽ 14.2	0.560	3.6	0.142	E+C	
		⩽ 14.6	0.575	4	0.157	B+C	
		⩽ 15	0.590	4.4	0.173	E+D	
		⩽ 15.4	0.606	4.8	0.189	B+D	
		⩽ 15.8	0.622	5.2	0.205	E+B+C	
		⩽ 16.2	0.638	5.6	0.220	C+D	
		⩽ 16.6	0.653	6	0.236	E+B+D	
		⩽ 17	0.669	6.4	0.252	D+D	
		⩽ 17.4	0.685	6.8	0.268	E+C+D	
		⩽ 17.8	0.701	7.2	0.283	C+C+C	
		⩽ 18.2	0.716	7.6	0.299	D+D+E	
		⩽ 18.6	0.732	8	0.315	C+C+D	

N_SB_571131_5_CCAA_02_00

Figure A-FCCAA - Sheet 02
Definition of the Washer Thickness for the Original Taperlok

****CONF ALL**

VALID FOR ASNA2531 AND ASNA2532 NUT

DIAMETER CODE No.	D MIN.	D		R		WASHERS THICKNESSES CODES	EXAMPLES
		mm	in	mm	in		
7	1.02 mm (0.040 in)	⩽ 12.8	0.504	0.8	0.031	A	IF "D"⩽ 14.8 mm INSTALL THE WASHERS NSA5372–716EX + NSA5372–716BX
		⩽ 13.1	0.516	1.2	0.047	E	
		⩽ 13.5	0.531	1.6	0.063	B	
		⩽ 13.9	0.547	2	0.079	A+E	
		⩽ 14.3	0.563	2.4	0.094	C	
		⩽ 14.8	0.583	2.8	0.110	E+B	
		⩽ 15.1	0.594	3.2	0.126	D	
		⩽ 15.5	0.610	3.6	0.142	E+C	
		⩽ 15.9	0.626	4	0.157	B+C	
		⩽ 16.3	0.642	4.4	0.173	E+D	
		⩽ 16.8	0.661	4.8	0.189	B+D	
		⩽ 17.1	0.673	5.2	0.205	E+B+C	
		⩽ 17.5	0.689	5.6	0.220	C+D	
		⩽ 17.9	0.705	6	0.236	E+B+D	
		⩽ 18.3	0.720	6.4	0.252	D+D	
		⩽ 18.7	0.736	6.8	0.268	E+C+D	
		⩽ 19.1	0.752	7.2	0.283	C+C+C	
		⩽ 19.5	0.768	7.6	0.299	D+D+E	
		⩽ 19.9	0.783	8	0.315	C+C+D	
8	1.02 mm (0.040 in)	⩽ 13.5	0.531	0.8	0.031	A	IF "D"⩽ 15.1 mm INSTALL THE WASHER NSA5372–816CX
		⩽ 13.9	0.547	1.2	0.047	E	
		⩽ 14.3	0.563	1.6	0.063	B	
		⩽ 14.8	0.583	2	0.079	A+E	
		⩽ 15.1	0.594	2.4	0.094	C	
		⩽ 15.5	0.610	2.8	0.110	E+B	
		⩽ 15.9	0.626	3.2	0.126	D	
		⩽ 16.3	0.642	3.6	0.142	E+C	
		⩽ 16.8	0.661	4	0.157	B+C	
		⩽ 17.1	0.673	4.4	0.173	E+D	
		⩽ 17.5	0.689	4.8	0.189	B+D	
		⩽ 17.9	0.705	5.2	0.205	E+B+C	
		⩽ 18.3	0.720	5.6	0.220	C+D	
		⩽ 18.7	0.736	6	0.236	E+B+D	
		⩽ 19.1	0.752	6.4	0.252	D+D	
		⩽ 19.5	0.768	6.8	0.268	E+C+D	
		⩽ 19.9	0.783	7.2	0.283	C+C+C	
		⩽ 20.3	0.799	7.6	0.299	D+D+E	

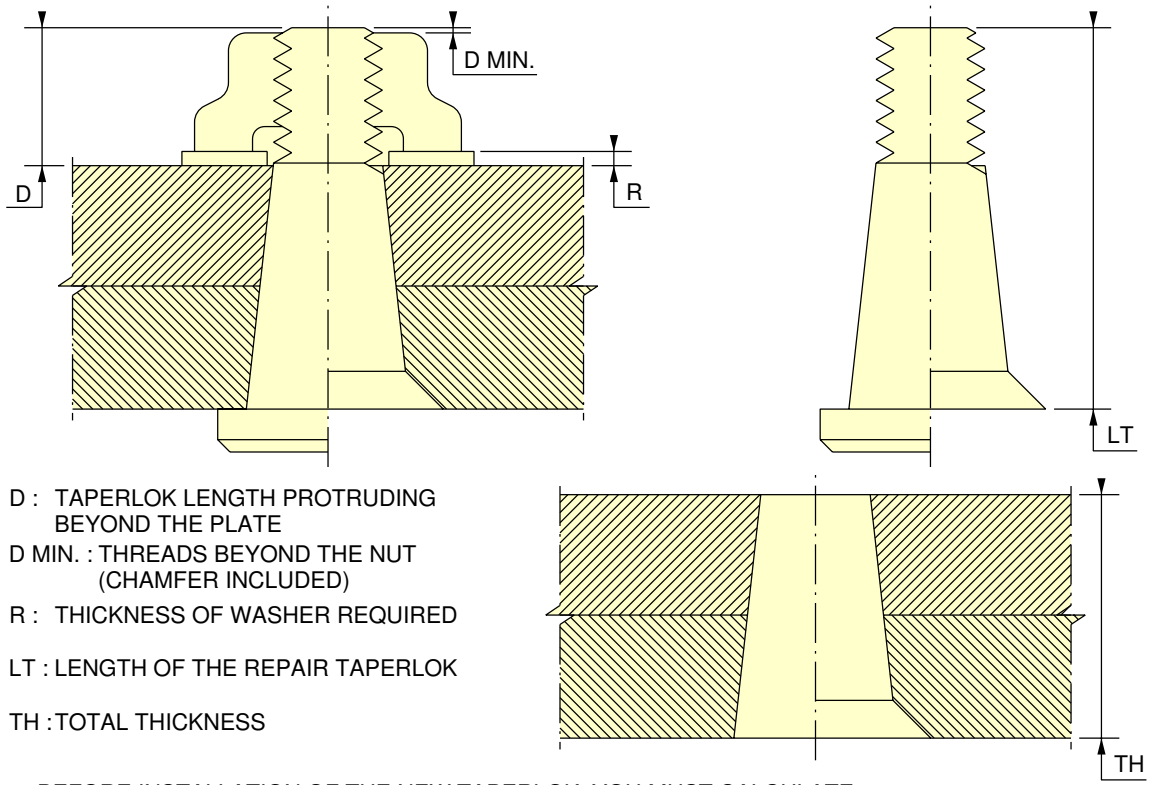
NOTE: IF NECESSARY, THE INSTALLATION OF THREE WASHERS IS APPROVED IN THIS CONDITION.

'N_SB_571131_5_CCAA_03_00

Figure A-FCCAA - Sheet 03
Definition of the Washer Thickness for the Original Taperlok

**CONF ALL

DEFINITION OF THE WASHER THICKNESS
FOR THE NEW TAPERLOK



D : TAPERLOK LENGTH PROTRUDING BEYOND THE PLATE

D MIN. : THREADS BEYOND THE NUT (CHAMFER INCLUDED)

R : THICKNESS OF WASHER REQUIRED

LT : LENGTH OF THE REPAIR TAPERLOK

TH : TOTAL THICKNESS

BEFORE INSTALLATION OF THE NEW TAPERLOK, YOU MUST CALCULATE THE "D" VALUE : D = LT – TH

TABLE ONLY VALID FOR THE OPTIONAL ABS1418 TAPERLOK

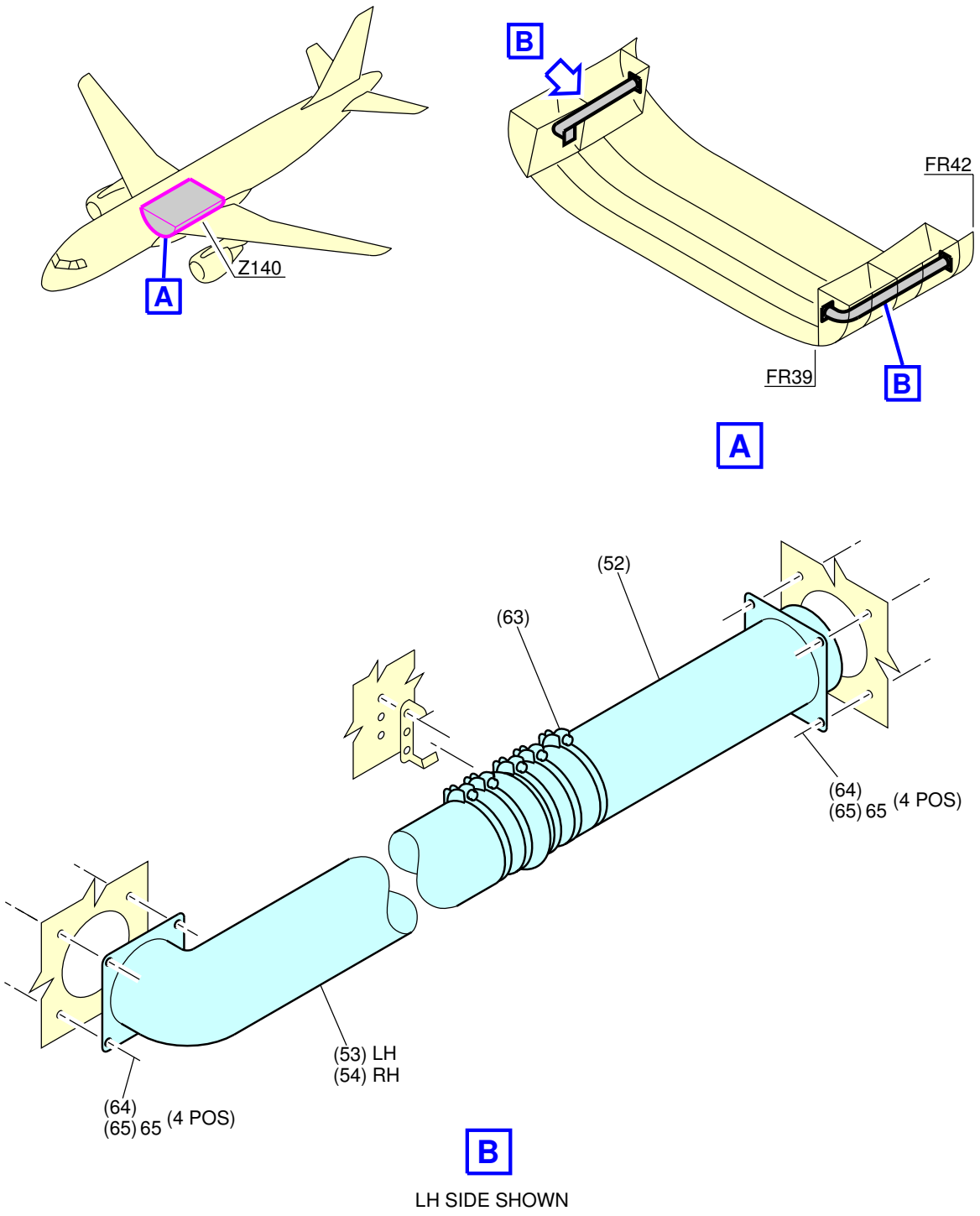
DIAMETER CODE No.	D MIN.	D		R		WASHERS THICKNESSES CODES	EXAMPLES
		mm	in	mm	in		
7	1.02 mm (0.040 in)	⩽12.6	0.496	0.8	0.031	A	IF "D" ⩽ 14.3 mm INSTALL THE WASHER NSA5372–816BX
		⩽13	0.512	1.2	0.047	E	
		⩽13.4	0.527	1.6	0.063	B	
8	1.02 mm (0.040 in)	⩽13.5	0.531	0.8	0.031	A	
		⩽13.9	0.547	1.2	0.047	E	
		⩽14.3	0.563	1.6	0.063	B	
9	1.14 mm (0.045 in)	⩽15.1	0.596	0.8	0.031	A	
		⩽15.5	0.612	1.2	0.047	E	
		⩽15.9	0.628	1.6	0.063	B	

NOTE:
IF THE LENGTH OF THE ABS1418 TAPERLOK IS CORRECTLY MEASURED, THE INSTALLATION OF THE WASHER IS NOT REQUIRED.

N_SB_571131_5_CDAA_01_02

Figure A-FCDAA - Sheet 01
Definition of the Washer Thickness for the New Taperlok

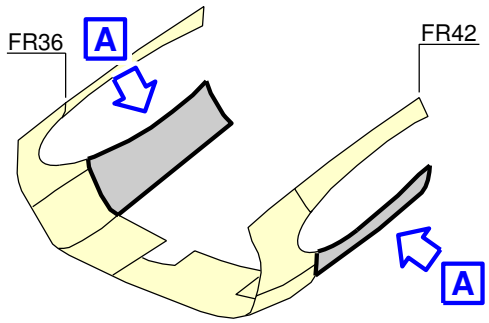
**CONF ALL

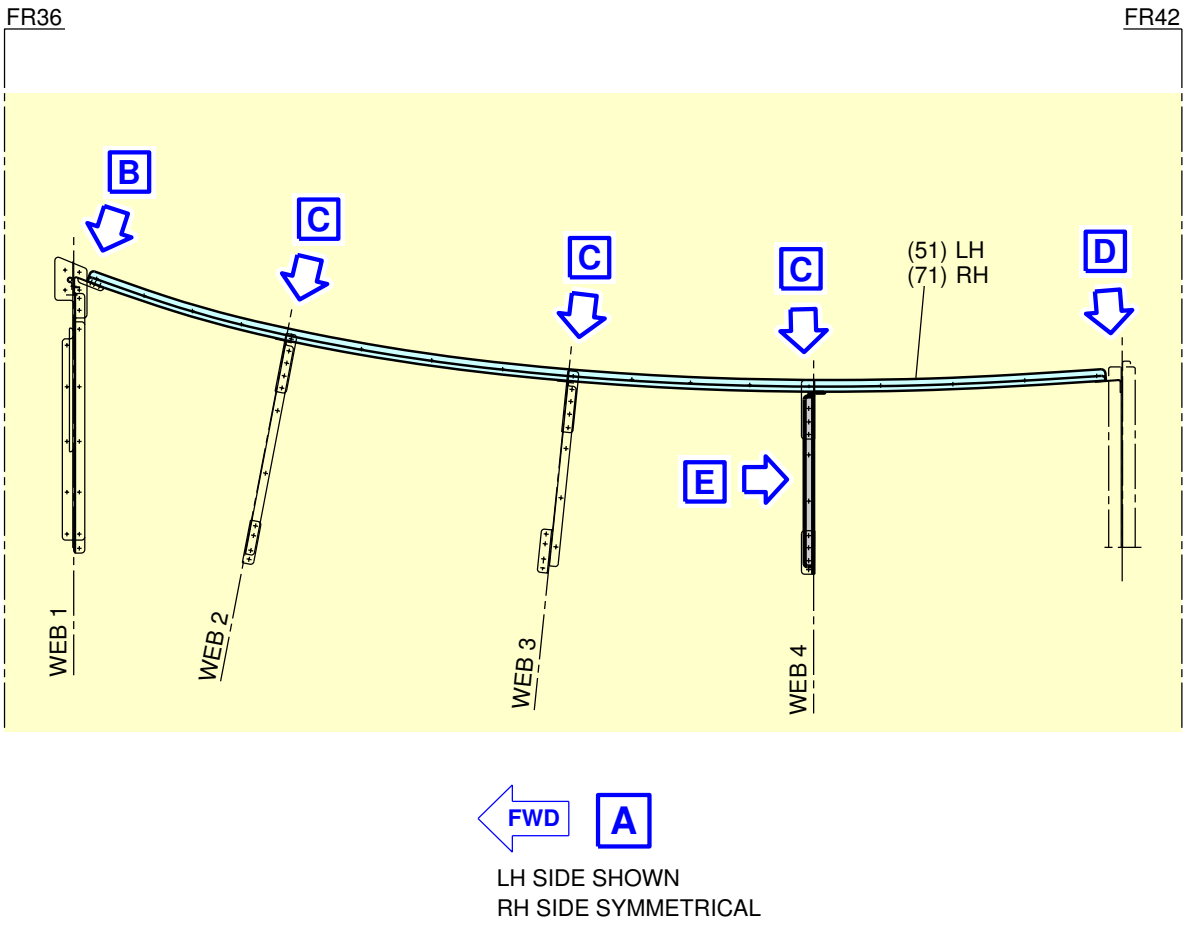


N_SB_571131_5_DAAA_01_01

Figure A-FDAAA - Sheet 01
Removal/Installation of the Cooling Duct

**CONF ALL

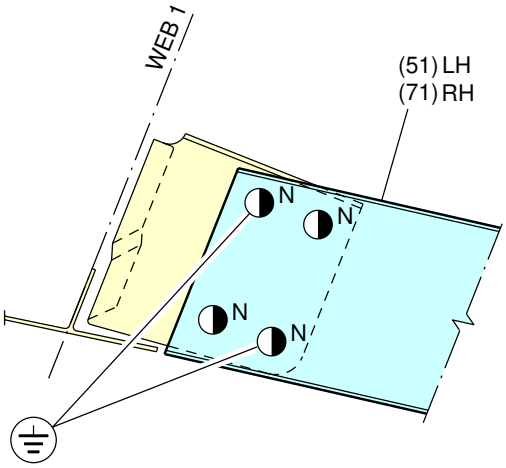




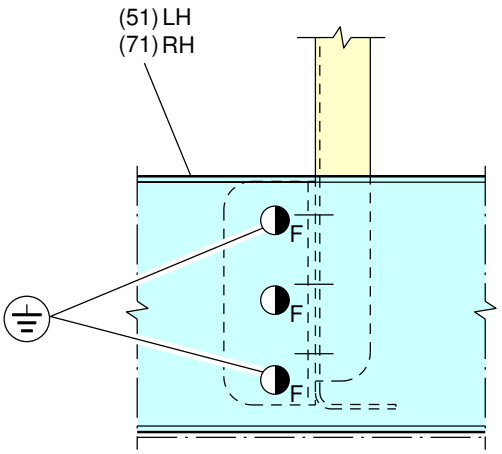
N_SB_571131_5_DBAA_01_01

Figure A-FDBAA - Sheet 01
Removal/Installation of the Belly Fairing Structure

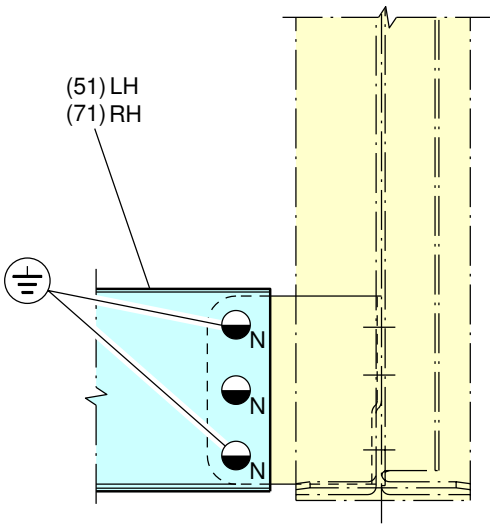
**CONF ALL



B



C



D

N HEAD ON VISIBLE SIDE

F HEAD ON HIDDEN SIDE

HOLE	OLD ITEM	NEW ITEM
◑	(60) (61)	60 61
◒	(62) (61)	62 61

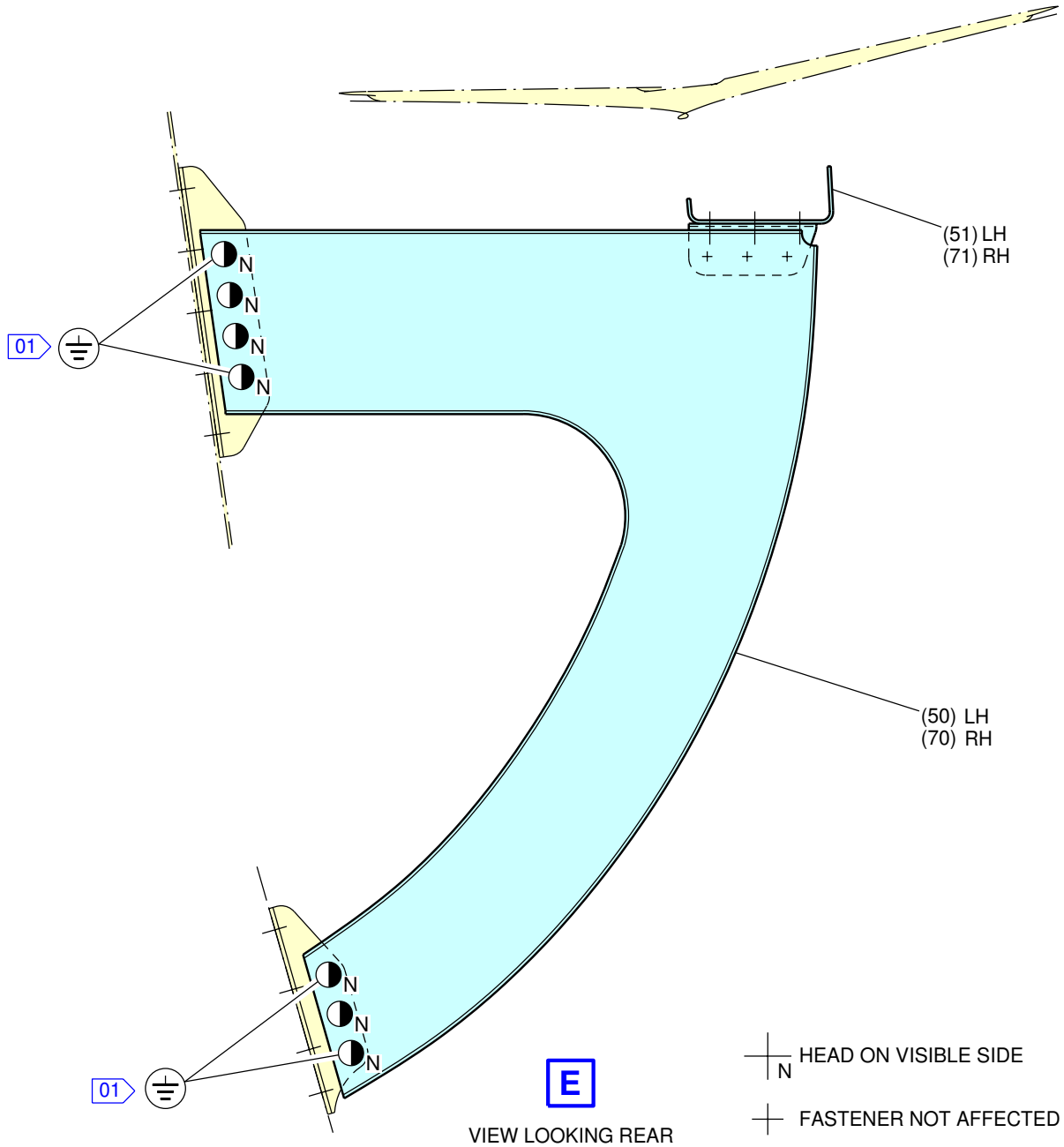
NOTE :

APPLY MAT. No 06AAA1 TO THE INTERFACES OF THE PARTS

N_SB_571131_5_DBAA_02_02

Figure A-FDBAA - Sheet 02
Removal/Installation of the Belly Fairing Structure

**CONF ALL



HOLE	OLD ITEM	NEW ITEM
◑	(60) (61)	60 61

NOTE:
APPLY MAT. No 06AAA1 TO THE INTERFACES
OF THE STRUCTURE AND ALL THE PARTS

01 DEPENDING ON AIRCRAFT CONFIGURATION

N_SB_571131_5_DBAA_03_03

Figure A-FDBAA - Sheet 03
Removal/Installation of the Belly Fairing Structure

**CONF ALL

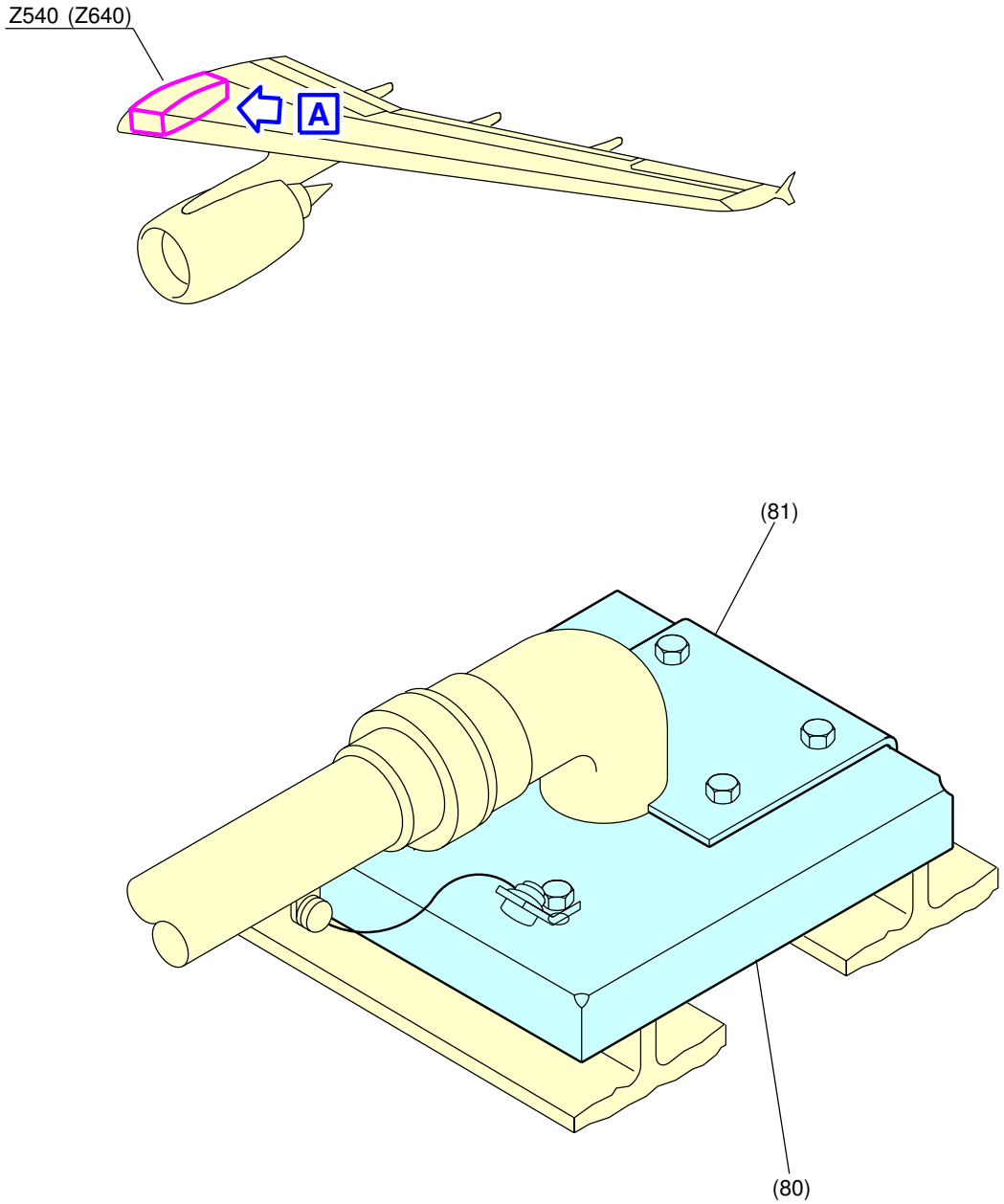
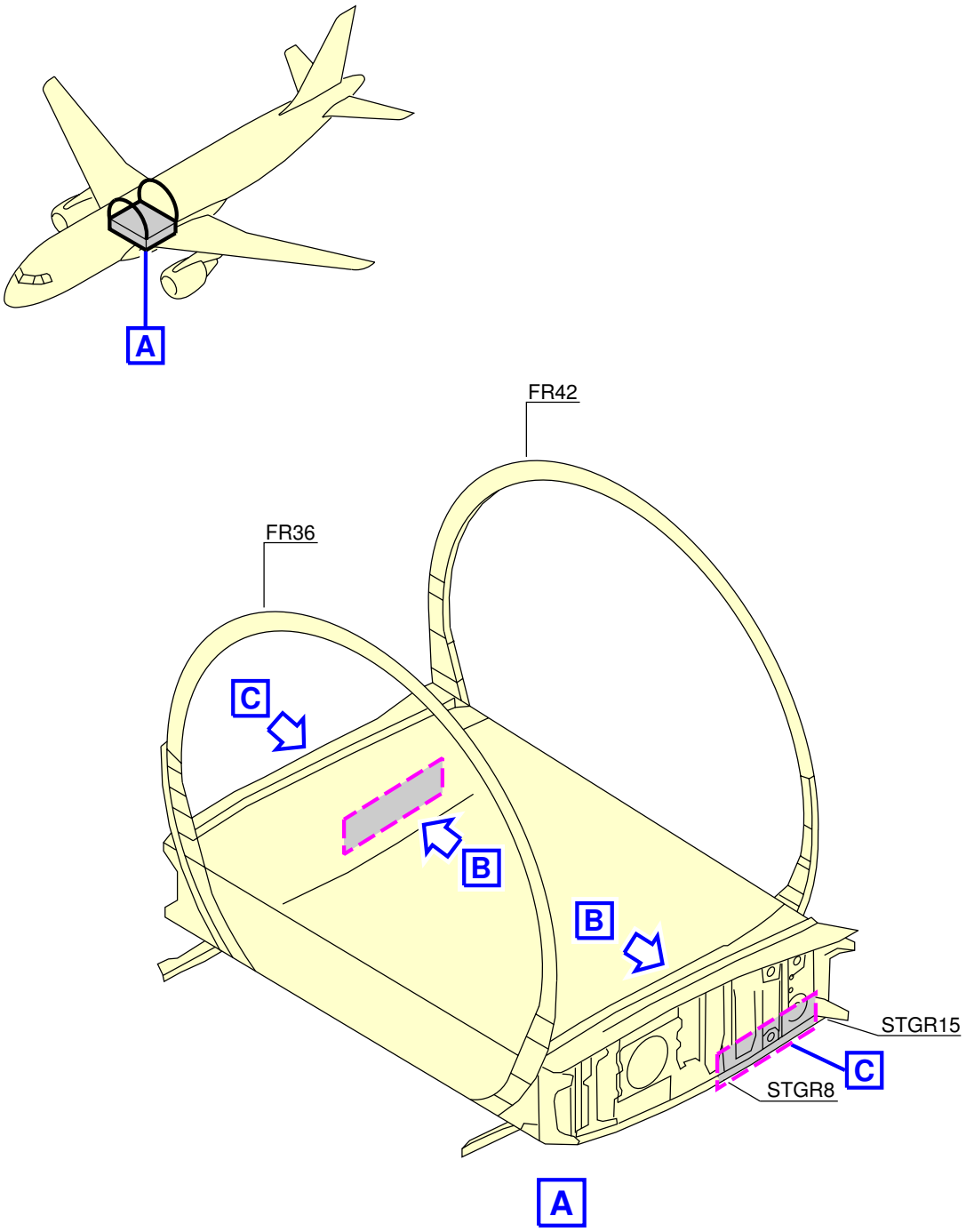


Figure A-FDCAA - Sheet 01
Removal/Installation of the Fuel Pump Strainer Covers

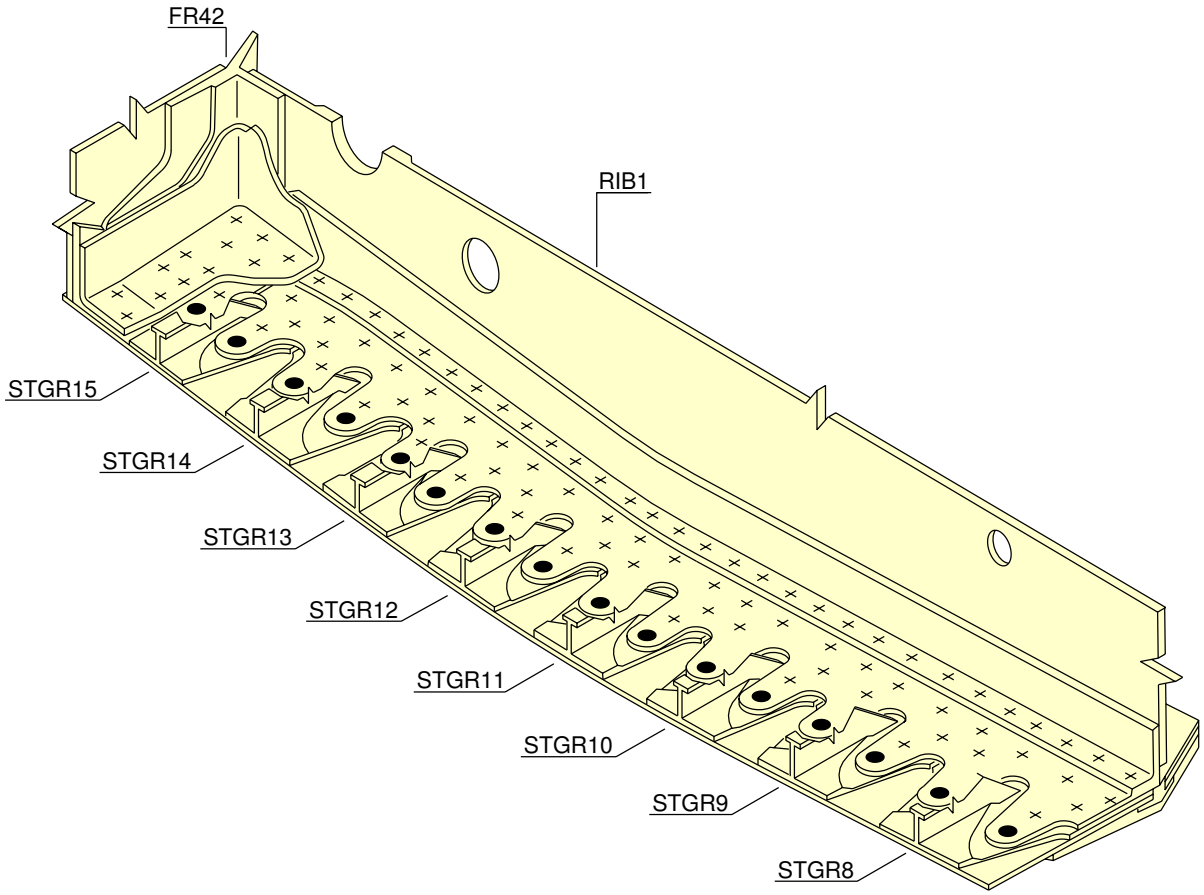
**CONF 001

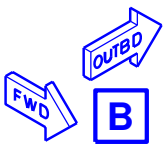


N_SB_571131_5_CEAA_01_01

Figure A-FCEAA - Sheet 01
Inspection of the Fasteners for the ADDITIONAL WORK

**CONF 001





VIEW LOOKING DOWN
LH SHOWN
RH SYMMETRICAL

NOTE:

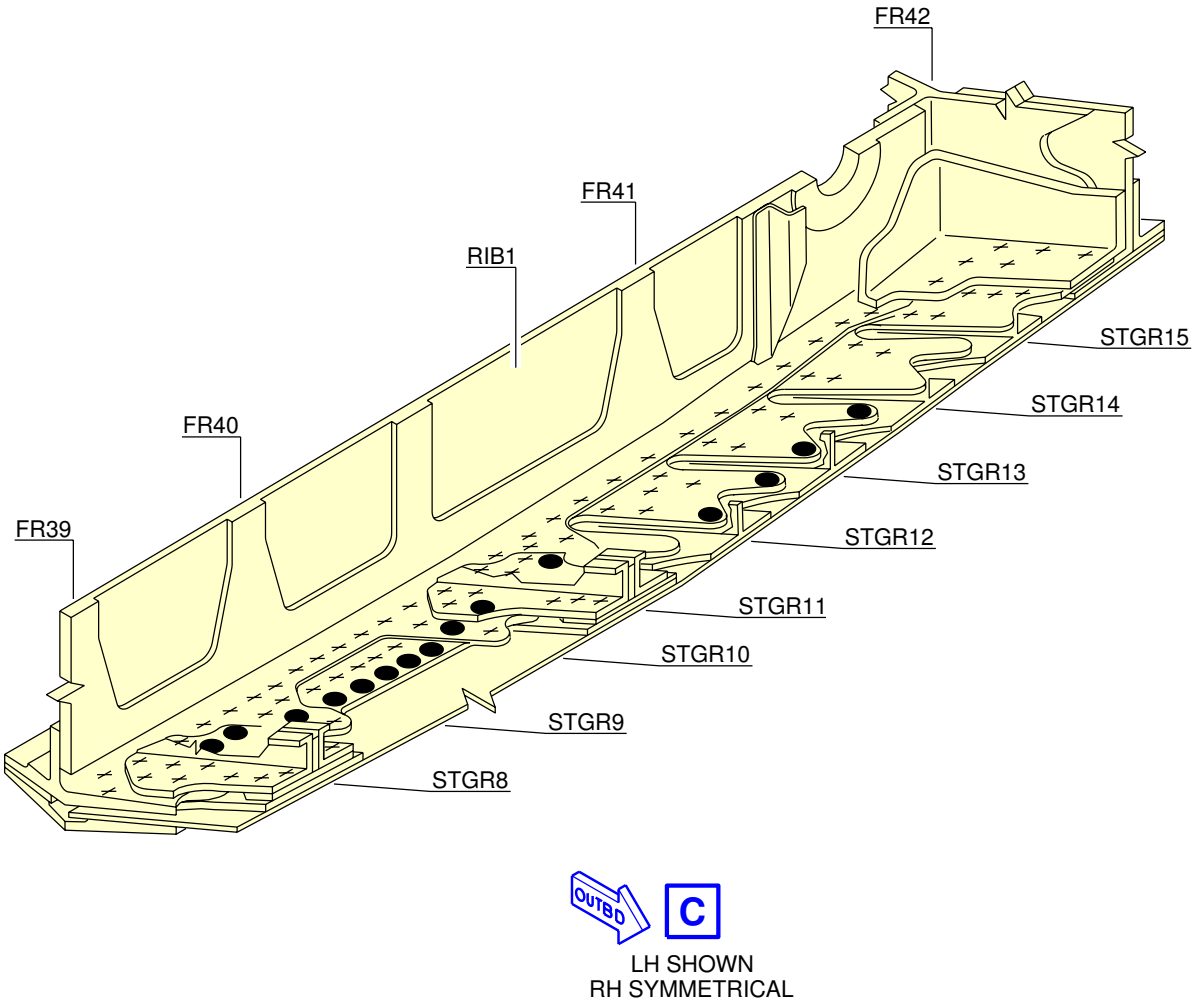
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CEAA_02_00

Figure A-FCEAA - Sheet 02
Inspection of the Fasteners for the ADDITIONAL WORK

**CONF 001



NOTE:

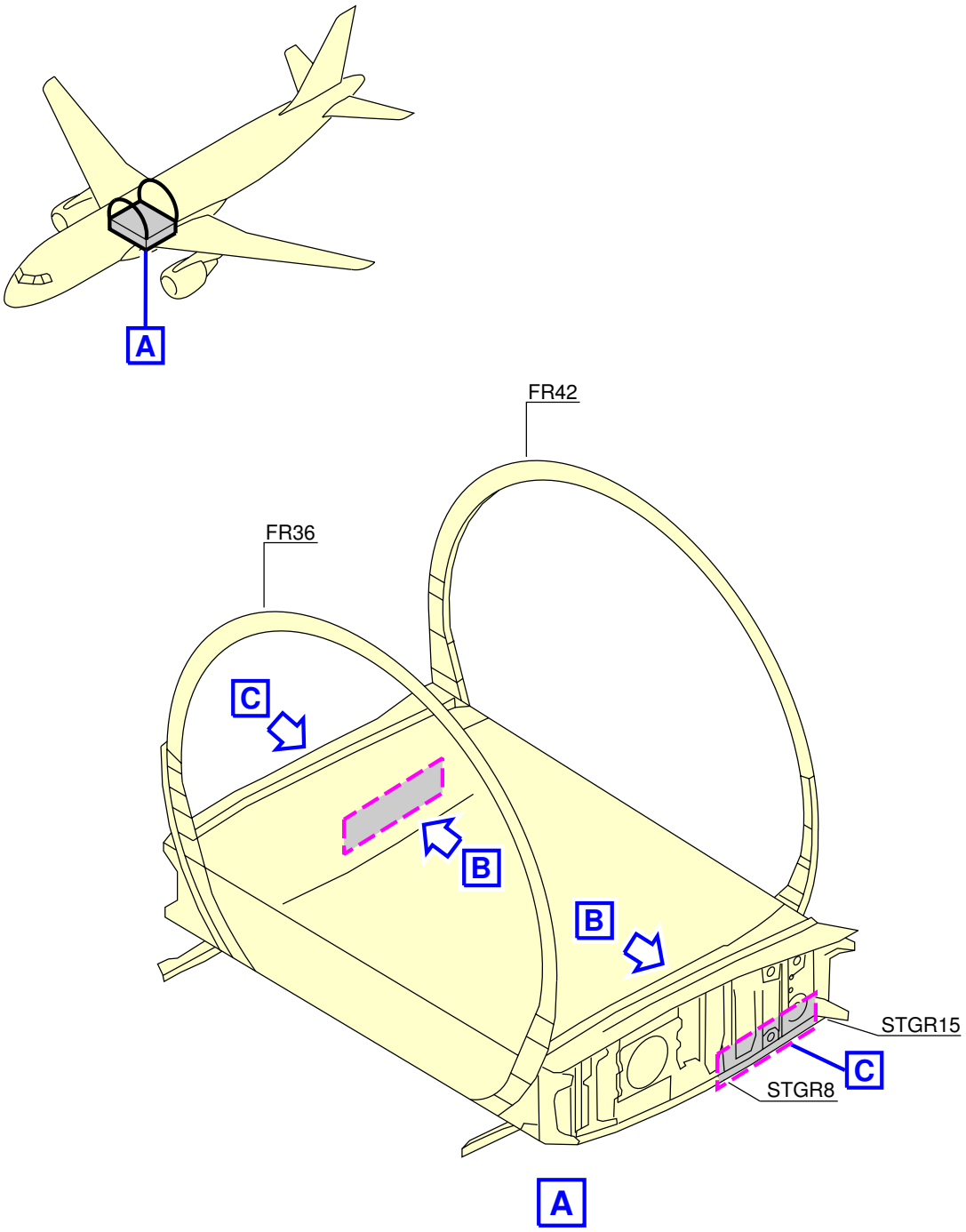
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CEAA_03_00

Figure A-FCEAA - Sheet 03
Inspection of the Fasteners for the ADDITIONAL WORK

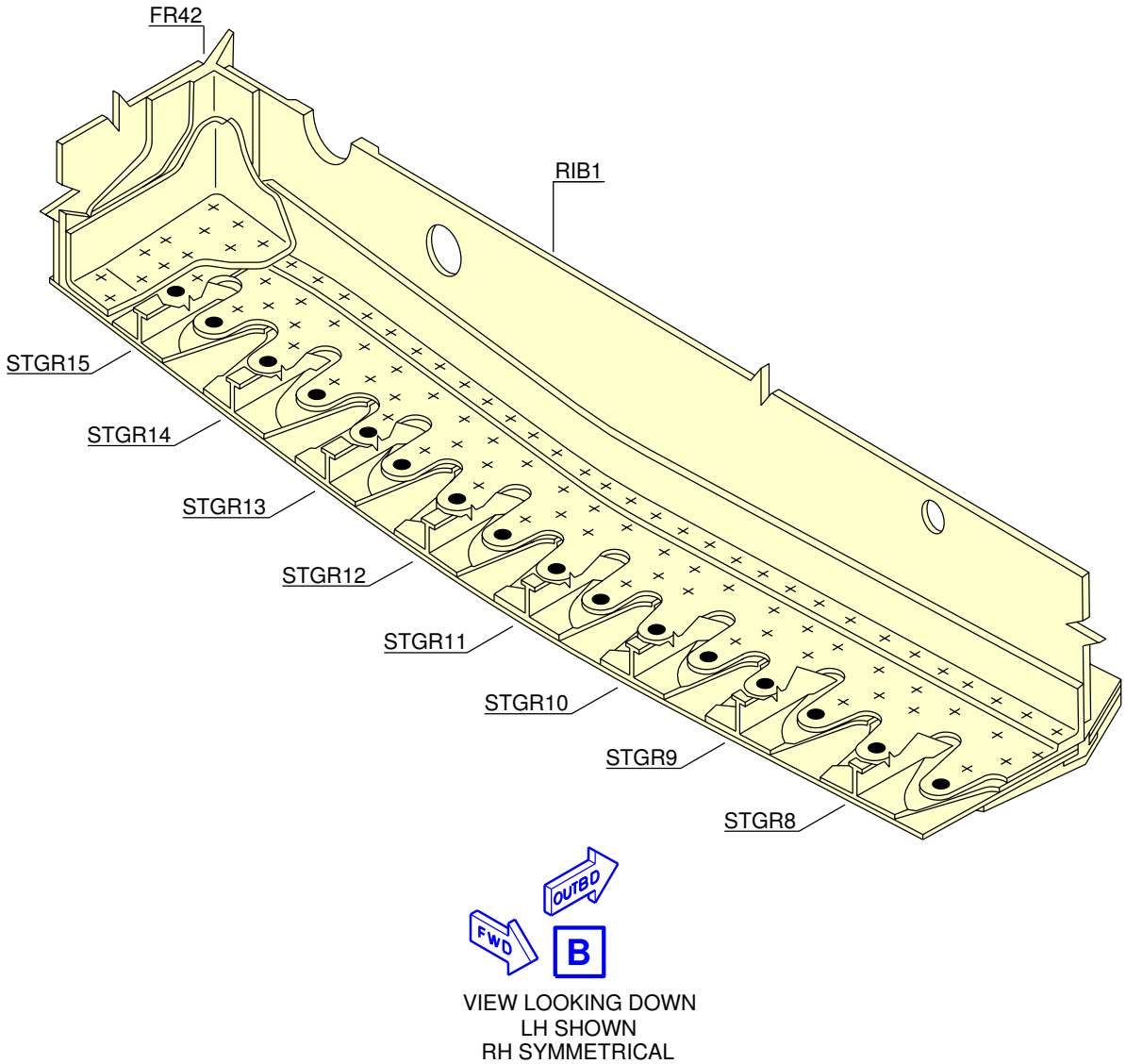
**CONF 002



N_SB_571131_5_CEAB_01_00

Figure A-FCEAB - Sheet 01
Inspection of the Fasteners for the ADDITIONAL WORK

**CONF 002



VIEW LOOKING DOWN
LH SHOWN
RH SYMMETRICAL

NOTE:

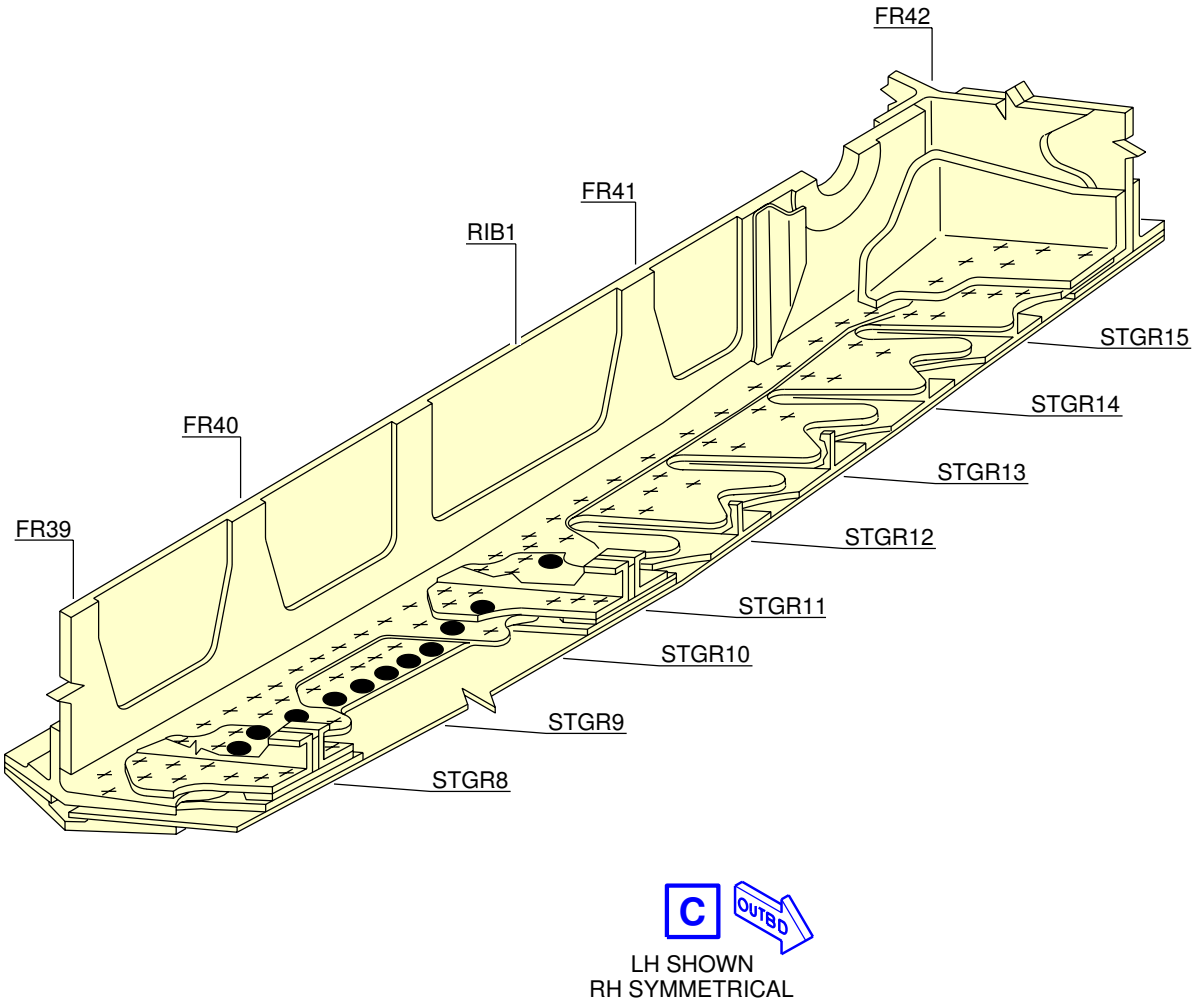
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CEAB_02_00

Figure A-FCEAB - Sheet 02
Inspection of the Fasteners for the ADDITIONAL WORK

**CONF 002



NOTE:

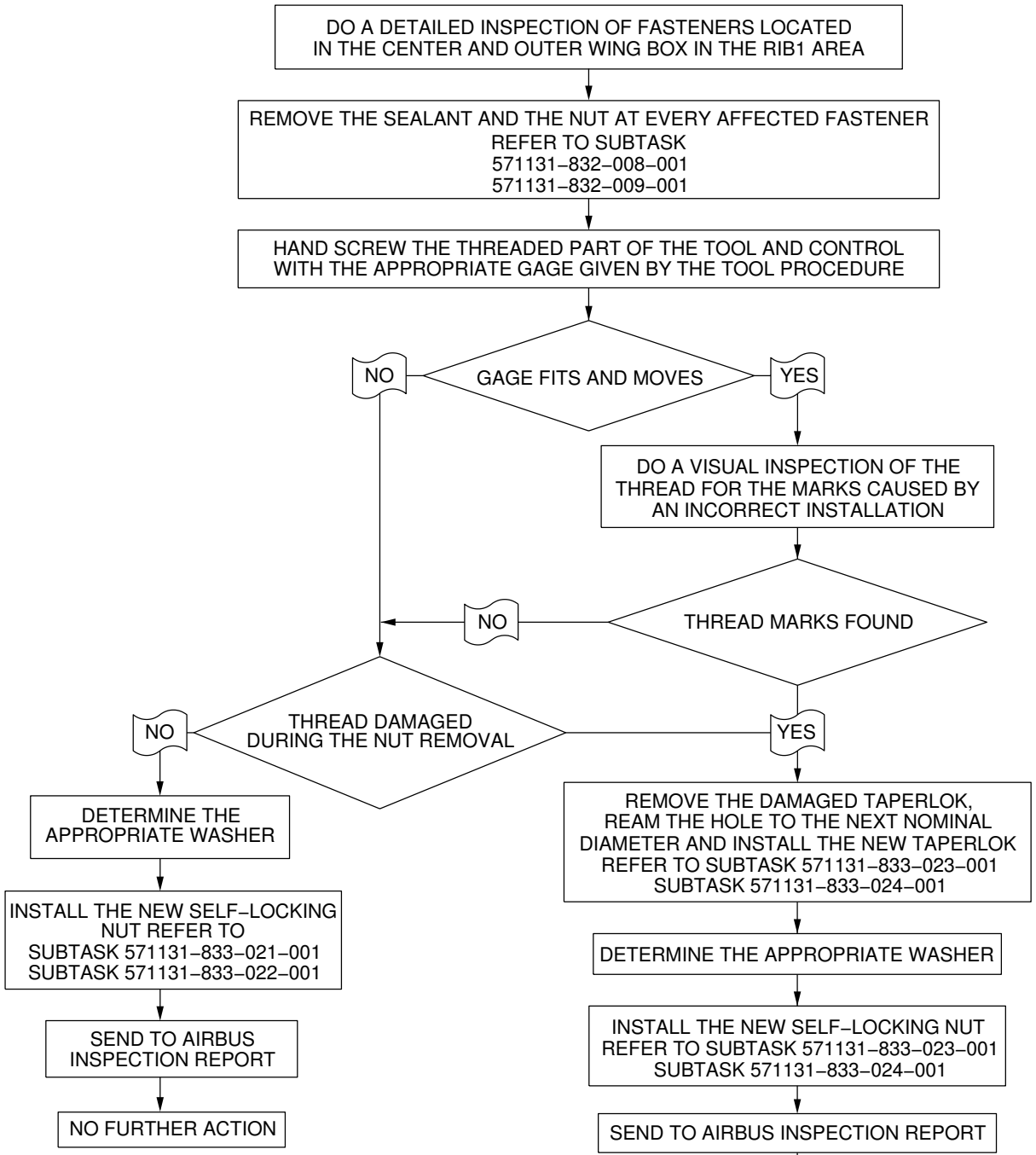
● HOLES TO BE INSPECTED

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CEAB_03_00

Figure A-FCEAB - Sheet 03
Inspection of the Fasteners for the ADDITIONAL WORK

**CONF 001



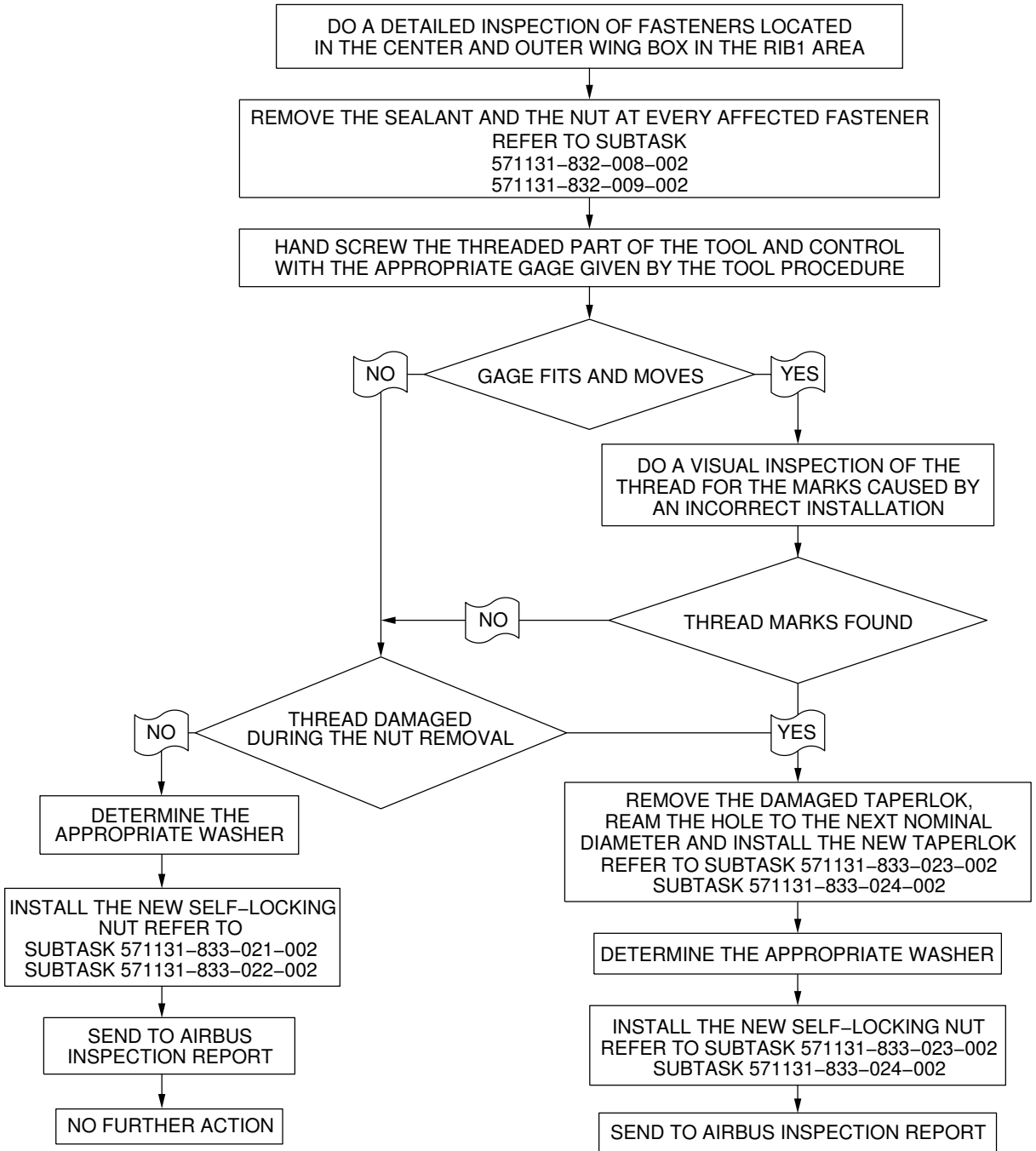
NOTE:

THE PURPOSE OF FLOW CHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

N_SB_571131_5_FBAA_01_04

Figure A-FFBAA - Sheet 01
Flow Chart for the ADDITIONAL WORK

**CONF 002



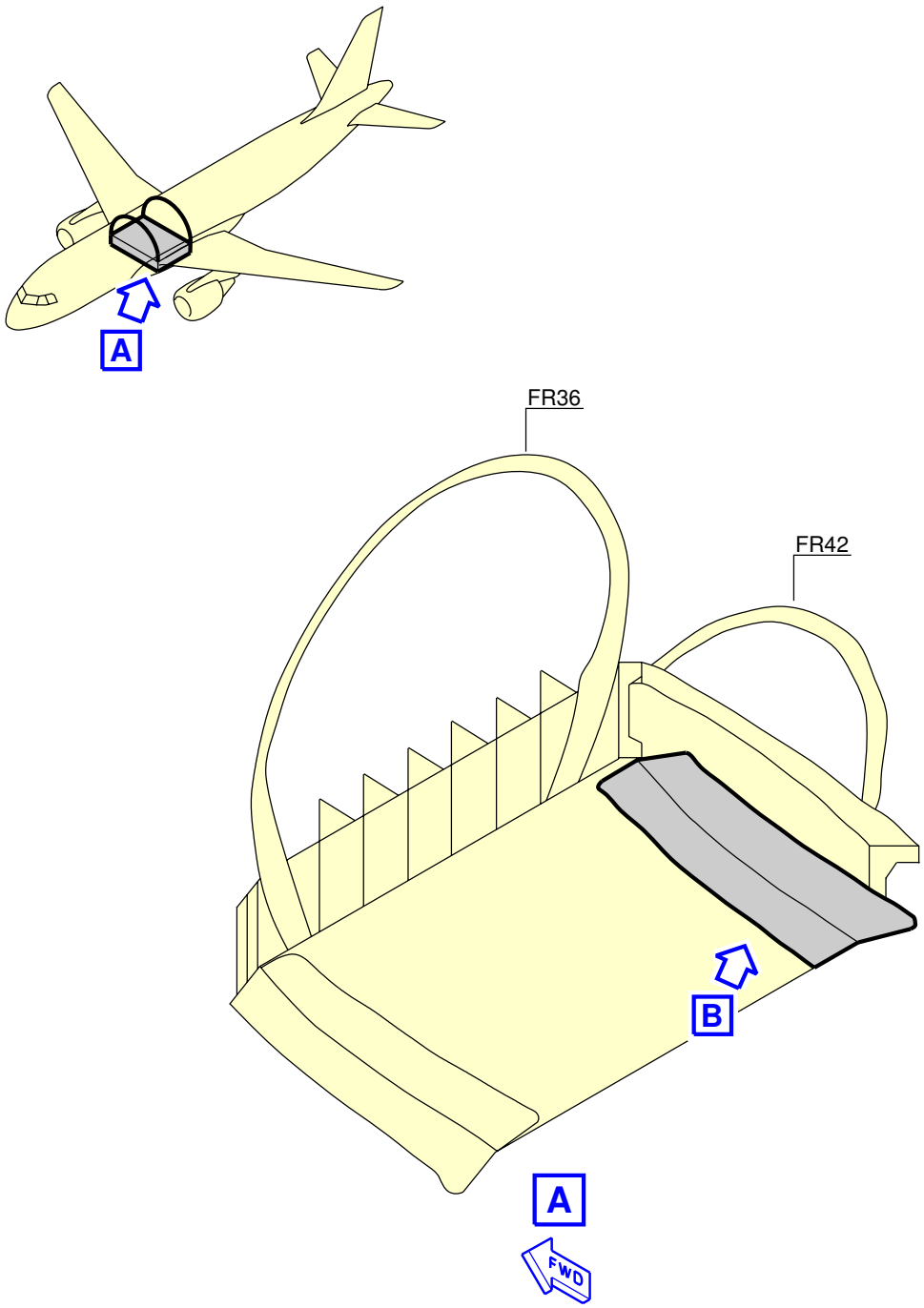
NOTE:

THE PURPOSE OF FLOW CHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

N_SB_571131_5_FBAB_01_03

Figure A-FFBAB - Sheet 01
Flow Chart for the ADDITIONAL WORK

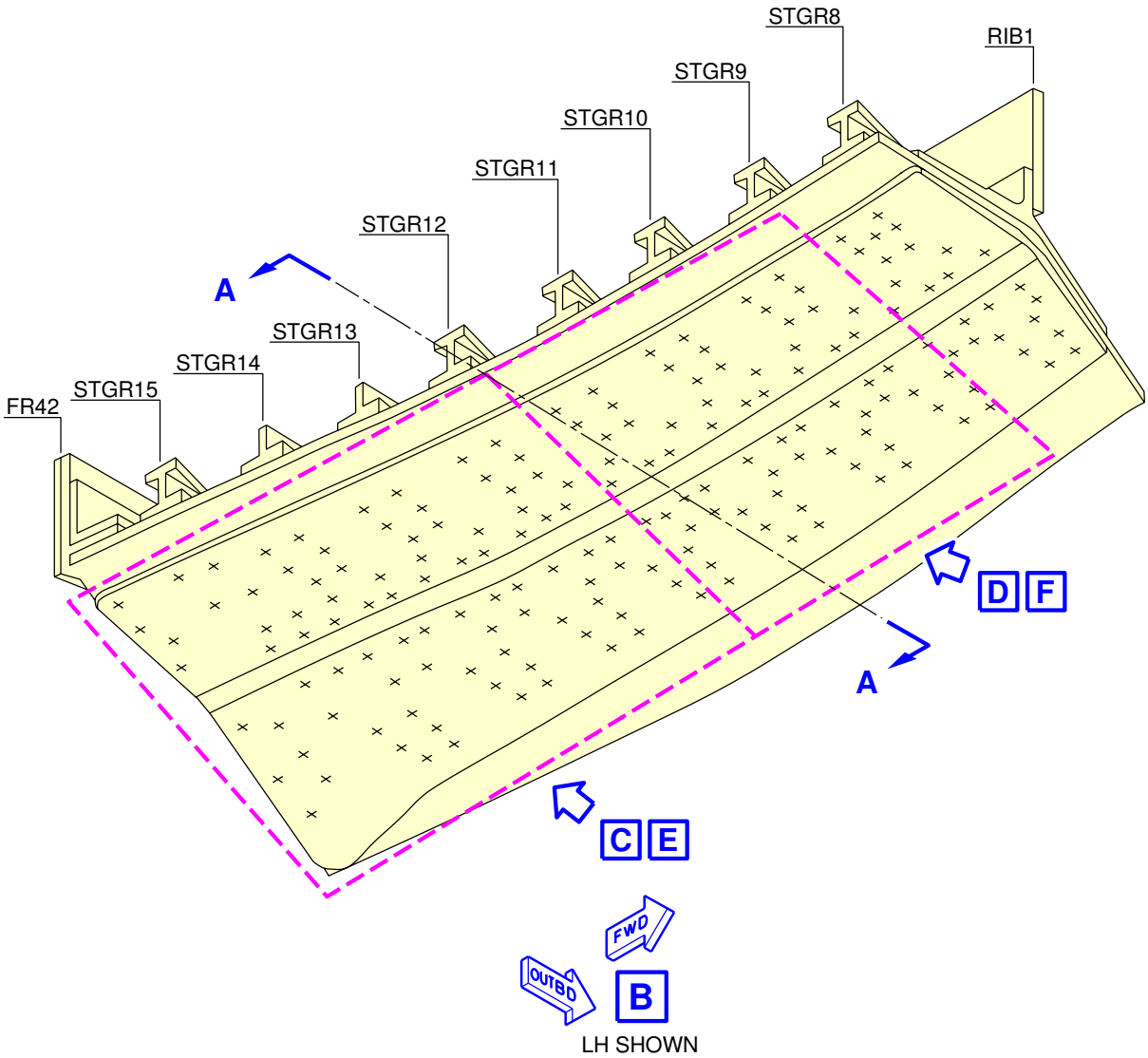
**CONF 001



N_SB_571131_5_CFAA_01_01

Figure A-FCFAA - Sheet 01
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

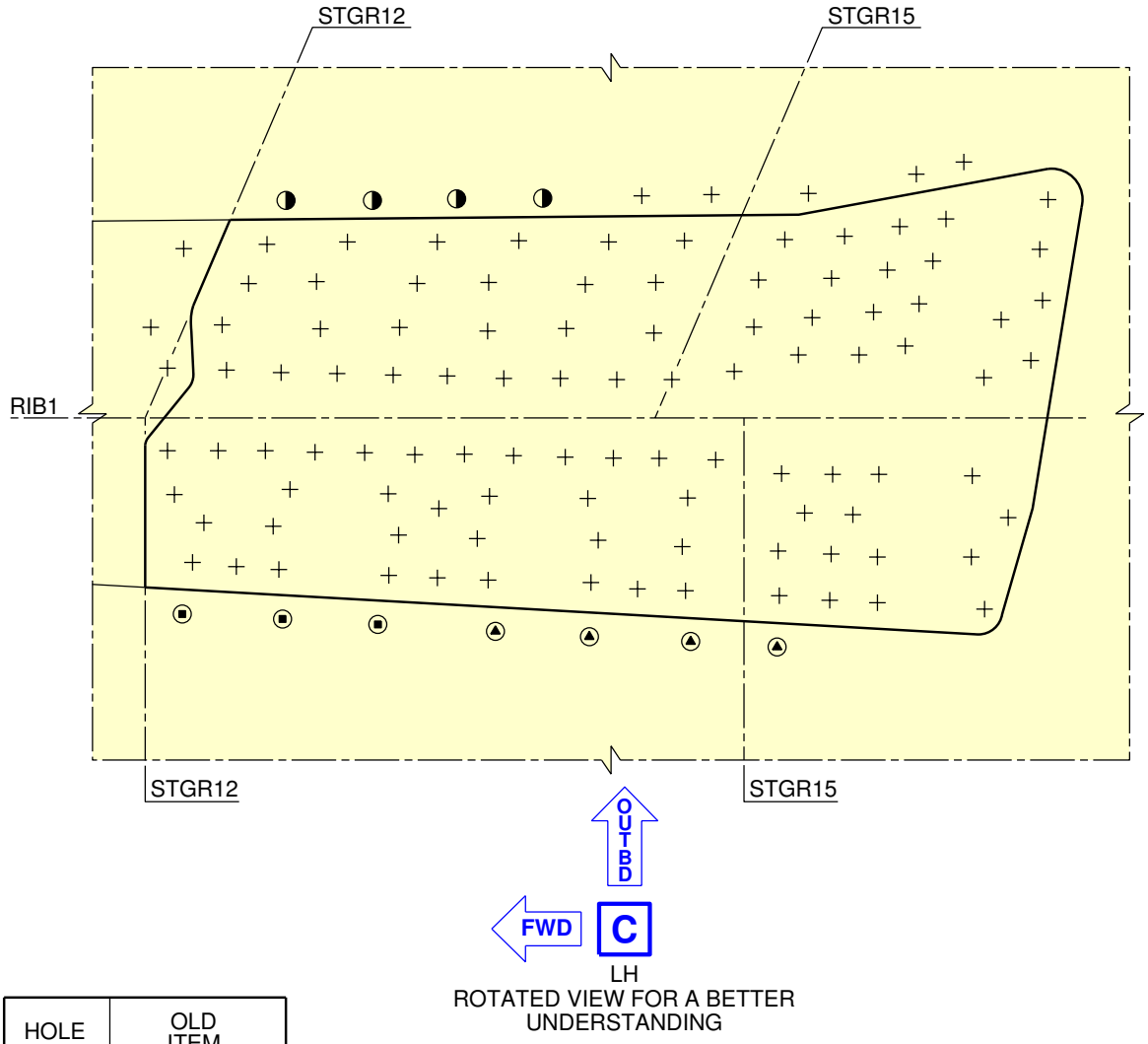


N_SB_571131_5_CFAA_02_00

Figure A-FCFAA - Sheet 02
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

BEFORE



HOLE	OLD ITEM
◑	(10) OR (3) (10)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

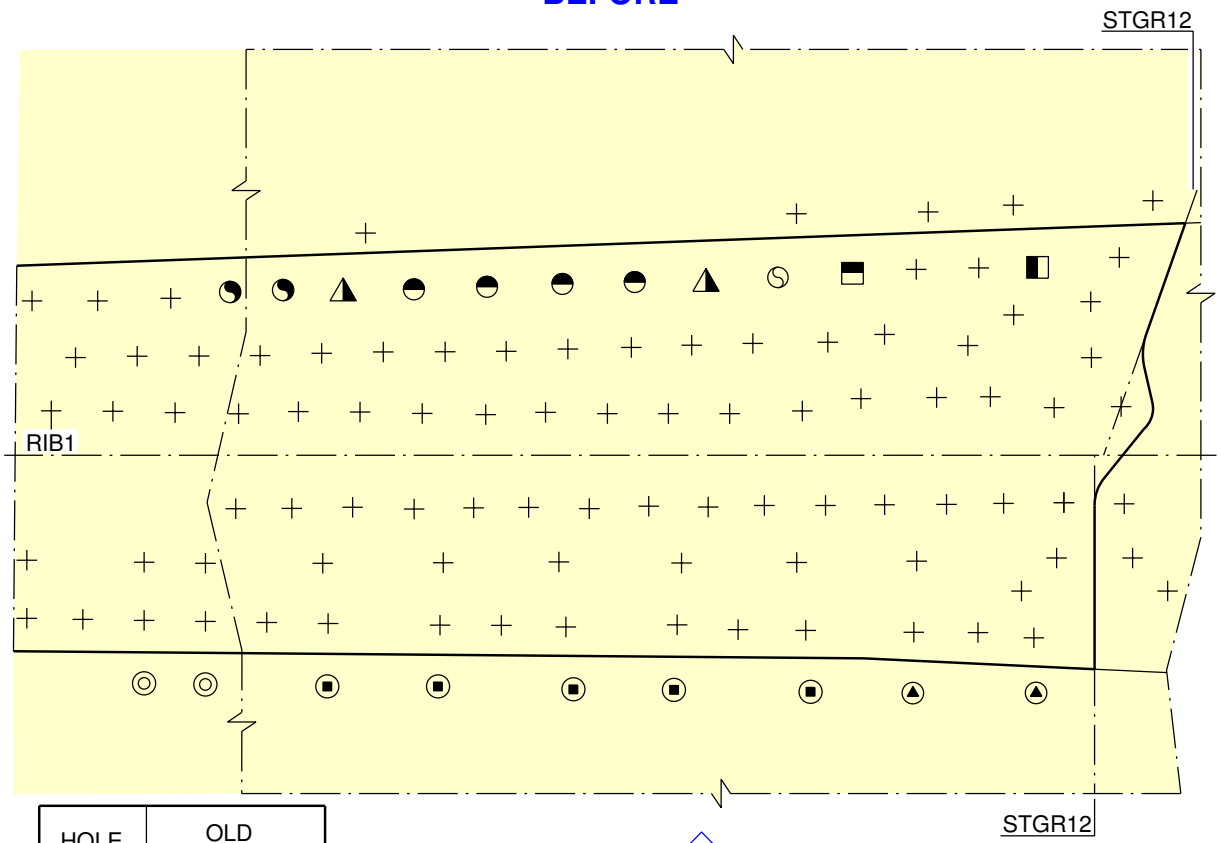
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CFAA_03_00

Figure A-FCFAA - Sheet 03
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

BEFORE



HOLE	OLD ITEM
◓	(10) OR (7) (10)
◭	(10) OR (77) (10)
⦸	(10) OR (81) (10)
◧	(11) OR (14) (11)
⬒	(11) OR (12) (11)
◎	(13) OR (70) (13)
▲	(13) OR (72) (13)
▣	(13) OR (71) (13)

FWD D OUTBD

LH

ROTATED VIEW FOR A BETTER UNDERSTANDING

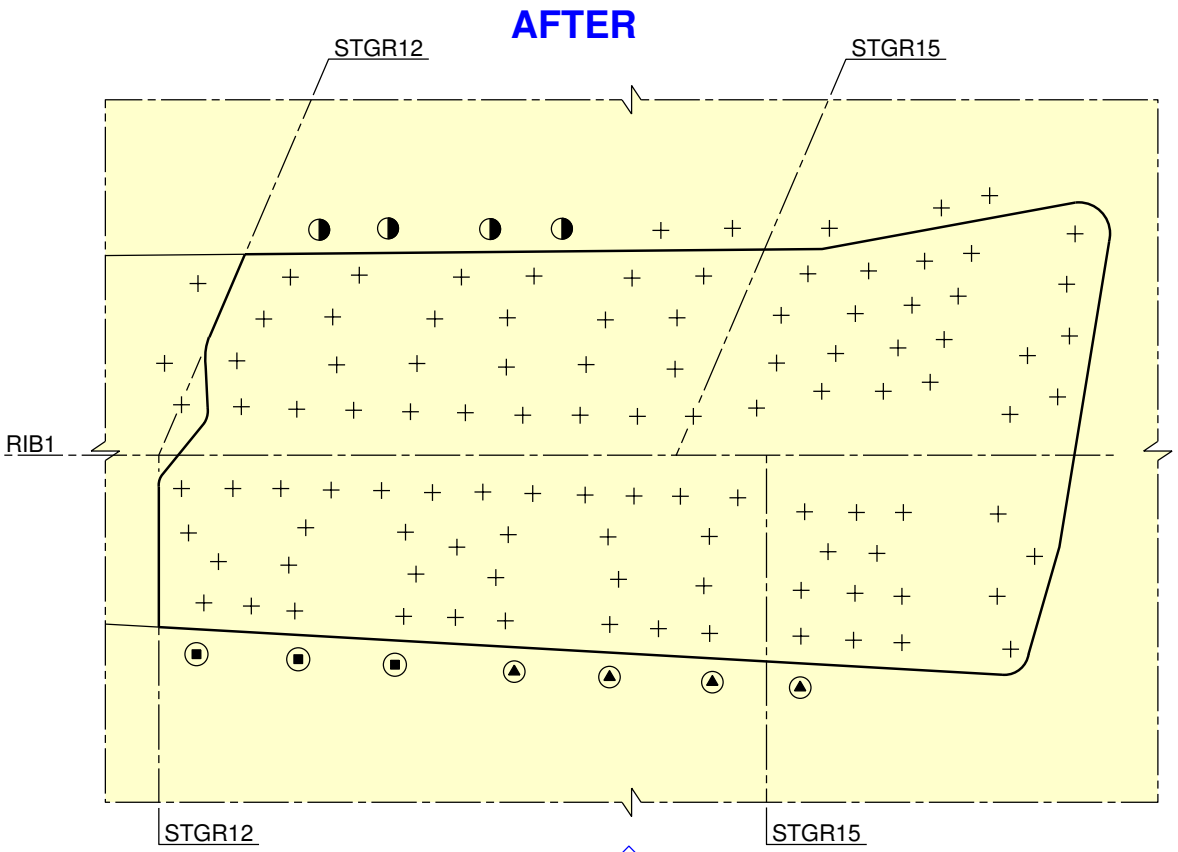
◔	(15) OR (79) (15)

+ FASTENERS NOT AFFECTED

N_SB_571131_5_CFAA_04_00

Figure A-FCFAA - Sheet 04
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001



HOLE	OLD ITEM
◑	10 OR 32 35
▲	13 OR 75 76
■	13 OR 74 76

┼ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA.

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in).

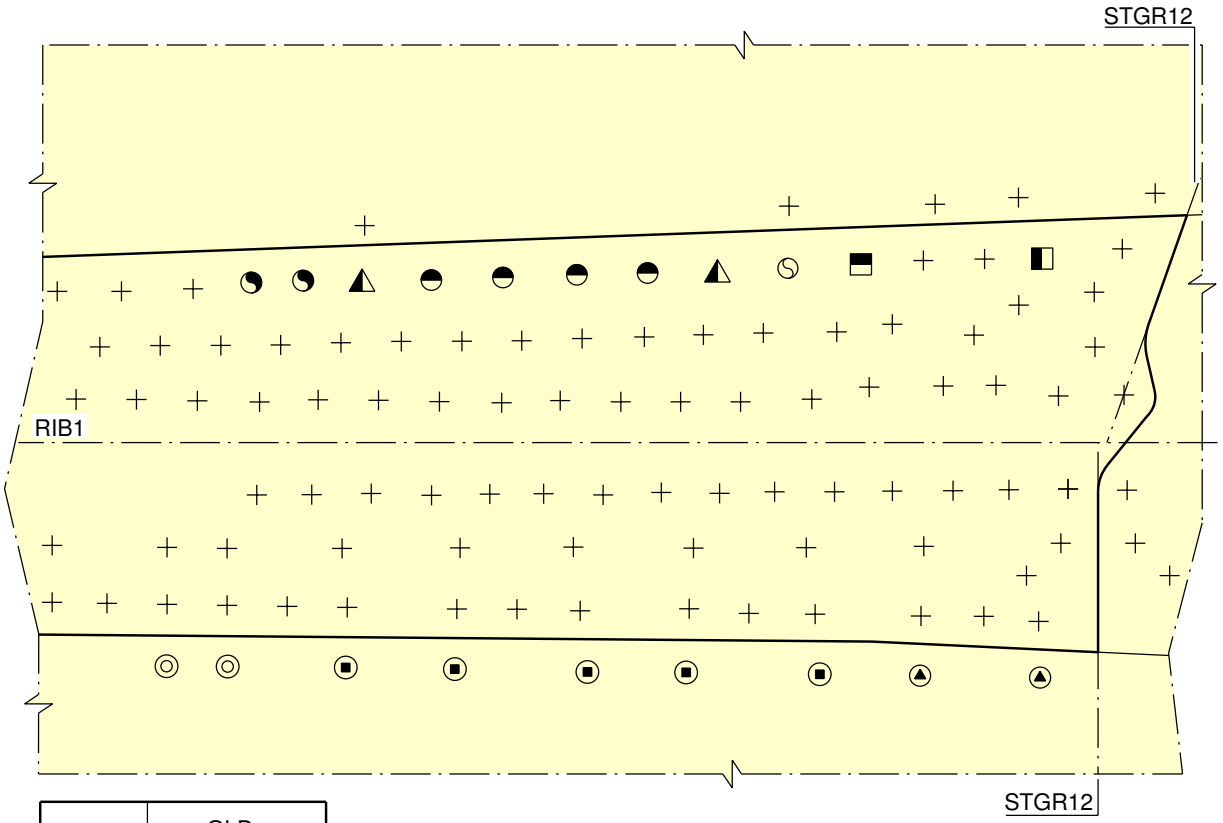
IN THE CASE OF THE REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in).

N_SB_571131_5_CFAA_05_00

Figure A-FCFAA - Sheet 05
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

AFTER



HOLE	OLD ITEM
◓	10 OR 34 35
◭	10 OR 78 35
⦸	10 OR 82 35
◧	11 OR 37 44
⬒	11 OR 43 44
◎	13 OR 73 76
▲	13 OR 75 76
◉	13 OR 74 76

FWD F OUTBD

LH

ROTATED VIEW FOR A BETTER UNDERSTANDING

◔	15 OR 80 11

+ FASTENERS NOT AFFECTED

NOTE :

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA.

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in).

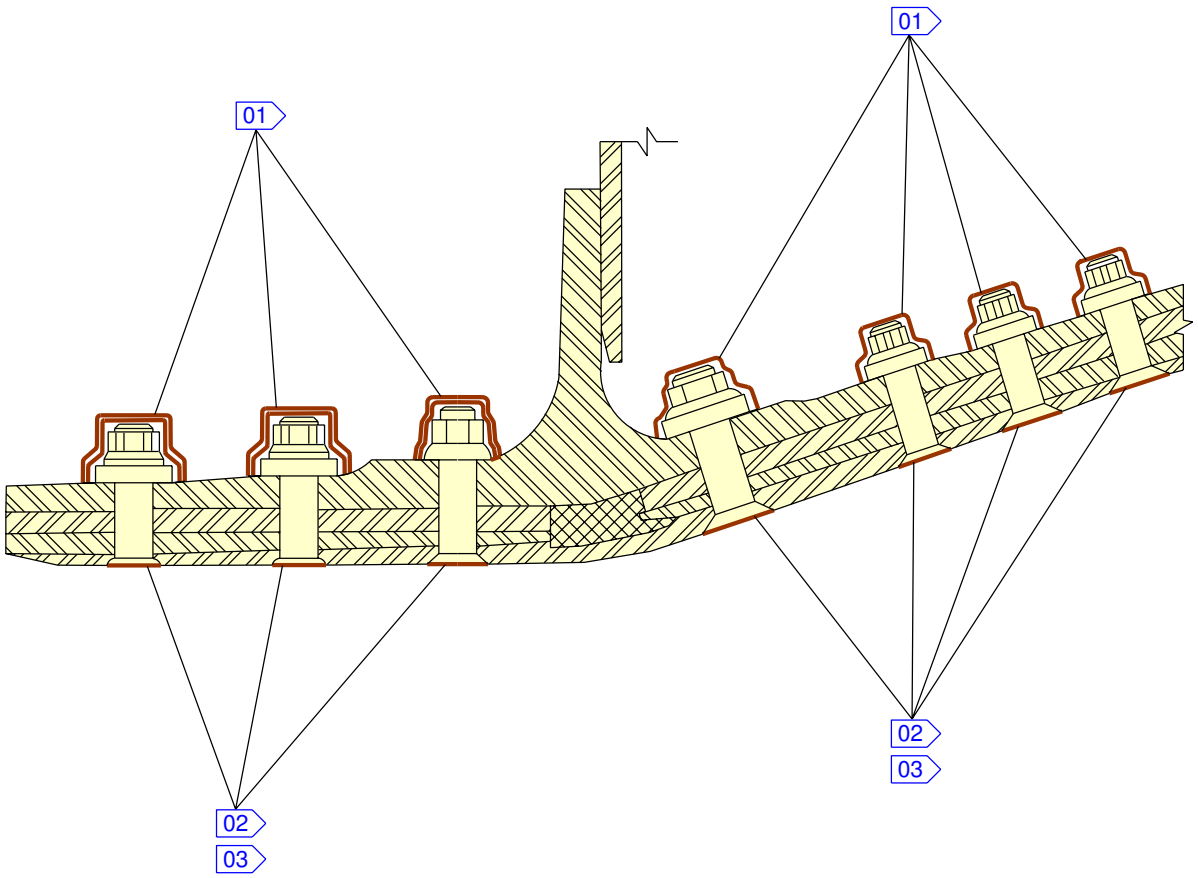
IN THE CASE OF THE REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in).

N_SB_571131_5_CFAA_06_01

Figure A-FCFAA - Sheet 06
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

SEALING PRINCIPLE



A - A

NOTE:

01 APPLY MAT. No 06AAB1 AND MAT. No 06PAG1 ON THE NUTS.

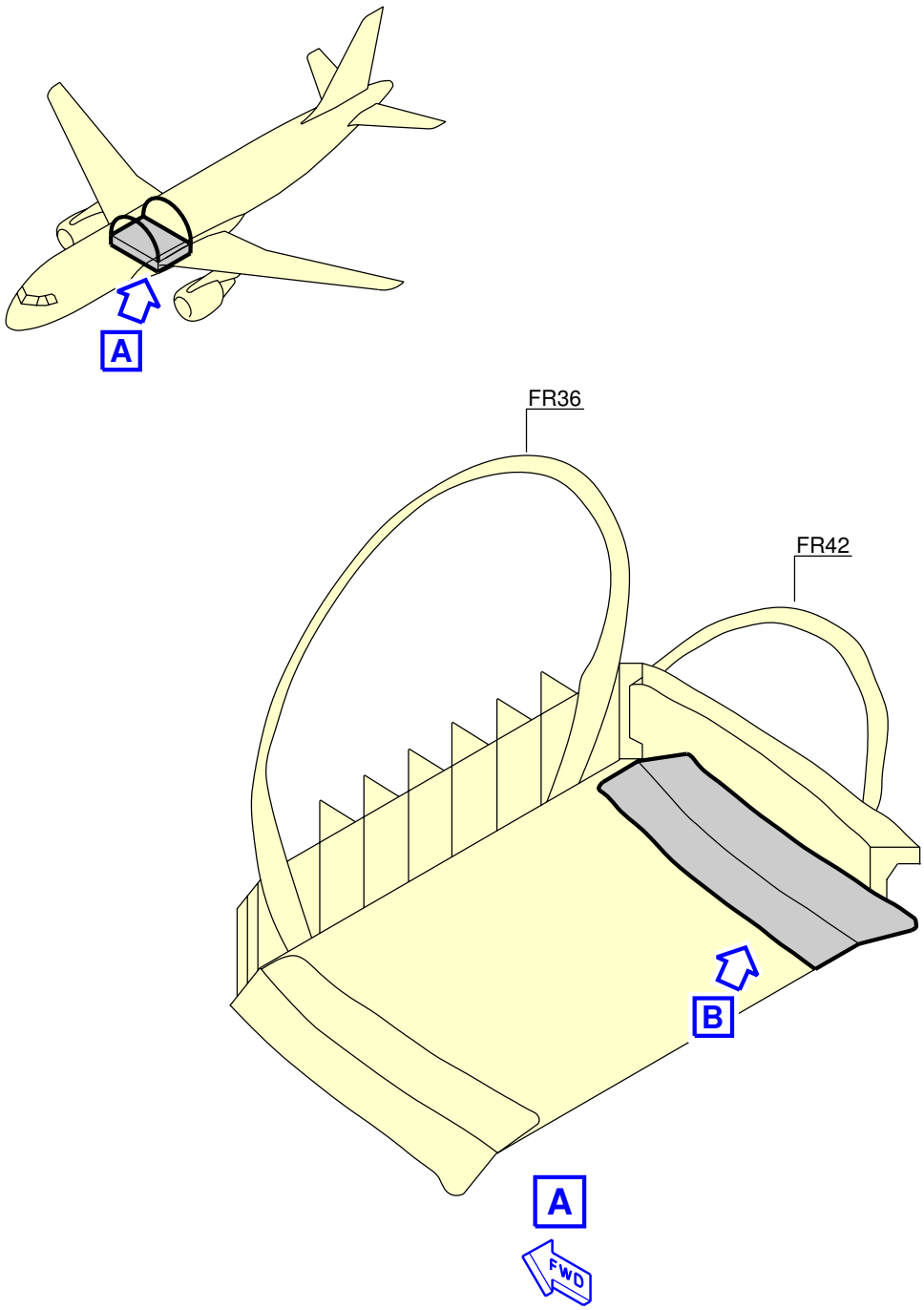
02 APPLY MAT. No 04EAC2, MAT. No 04CAA2 AND MAT. No 04JAA3 ON THE BOLTS.

03 WET ASSEMBLY, APPLY MAT. No 06ABB1.

N_SB_571131_5_CFAA_07_01

Figure A-FCFAA - Sheet 07
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

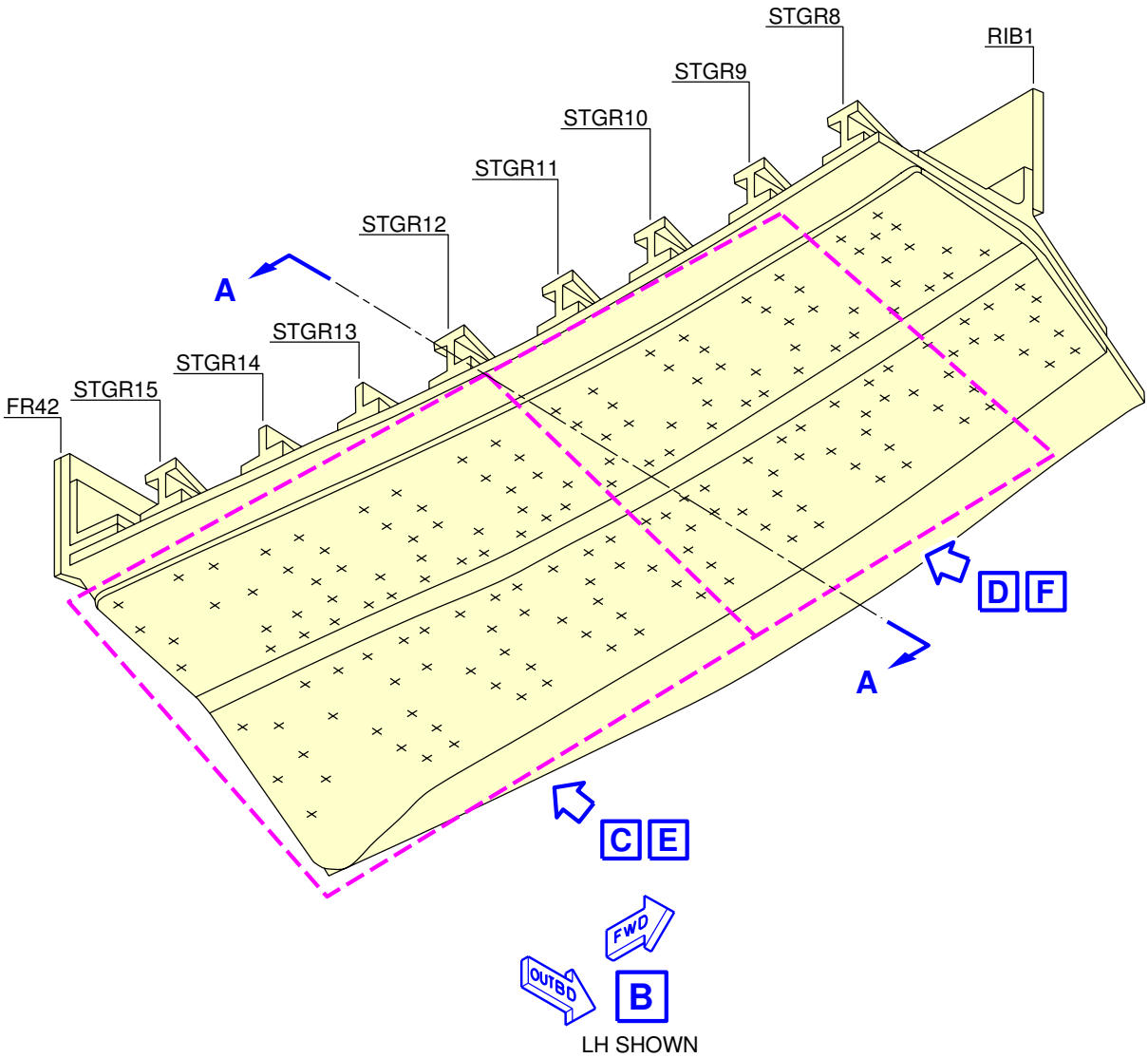
**CONF 002



N_SB_571131_5_CFAB_01_00

Figure A-FCFAB - Sheet 01
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

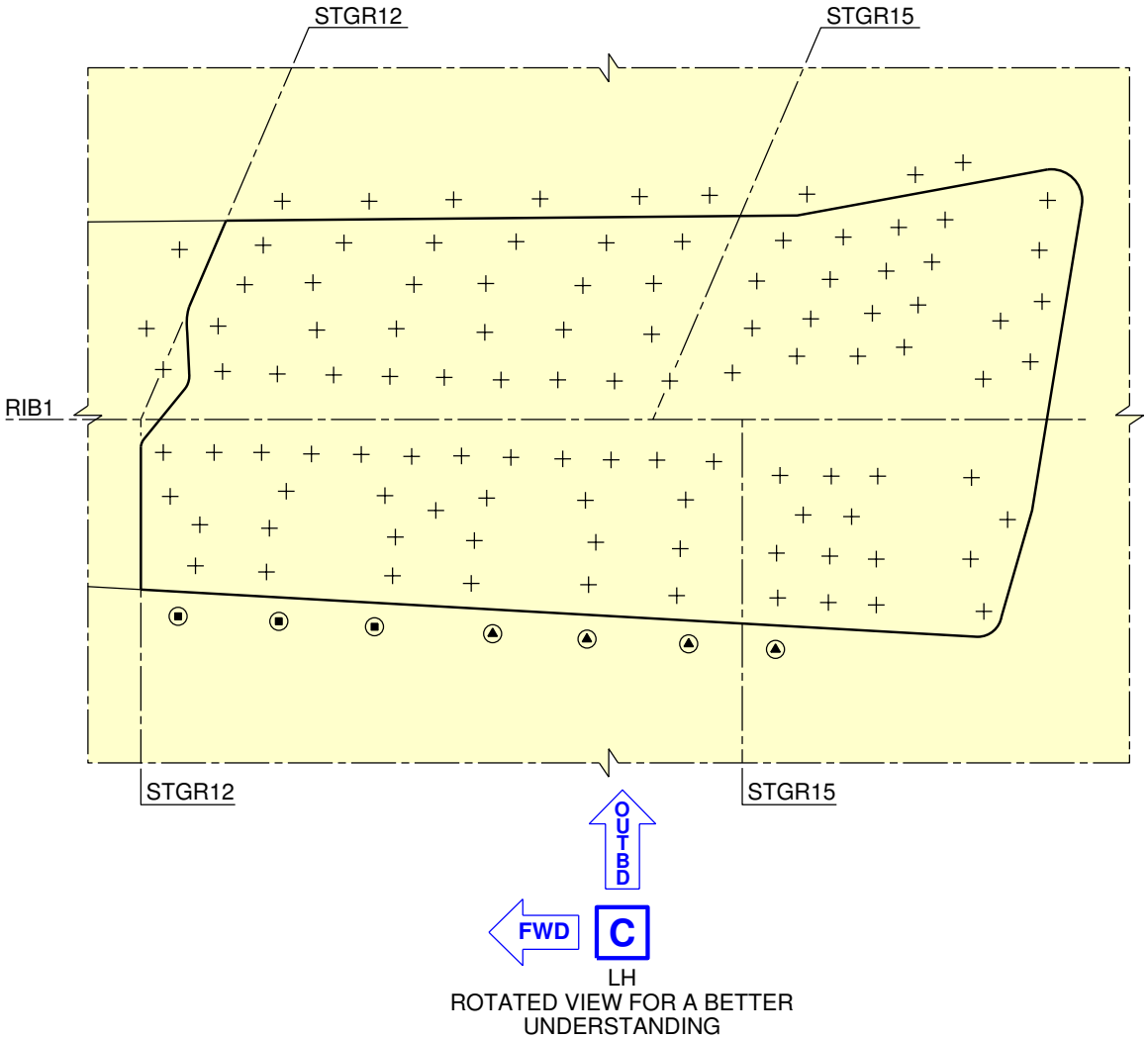


N_SB_571131_5_CFAB_02_00

Figure A-FCFAB - Sheet 02
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

BEFORE



ROTATED VIEW FOR A BETTER UNDERSTANDING

HOLE	OLD ITEM
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

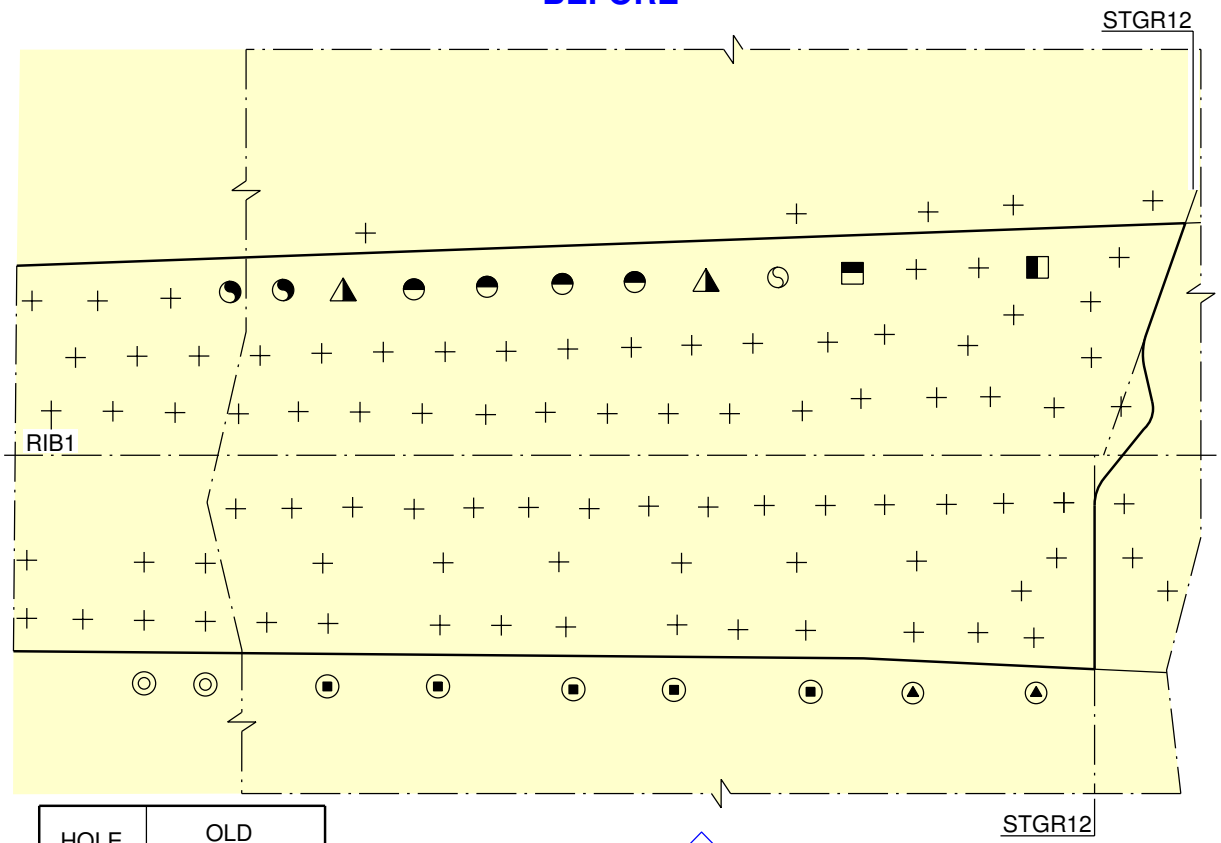
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CFAB_03_00

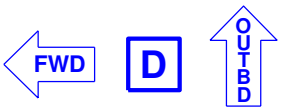
Figure A-FCFAB - Sheet 03
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

BEFORE



HOLE	OLD ITEM
◓	(10) OR (7) (10)
◭	(10) OR (77) (10)
⍉	(10) OR (81) (10)
◧	(11) OR (14) (11)
⬓	(11) OR (12) (11)
◎	(13) OR (70) (13)
▲	(13) OR (72) (13)
▣	(13) OR (71) (13)



LH
ROTATED VIEW FOR A BETTER UNDERSTANDING

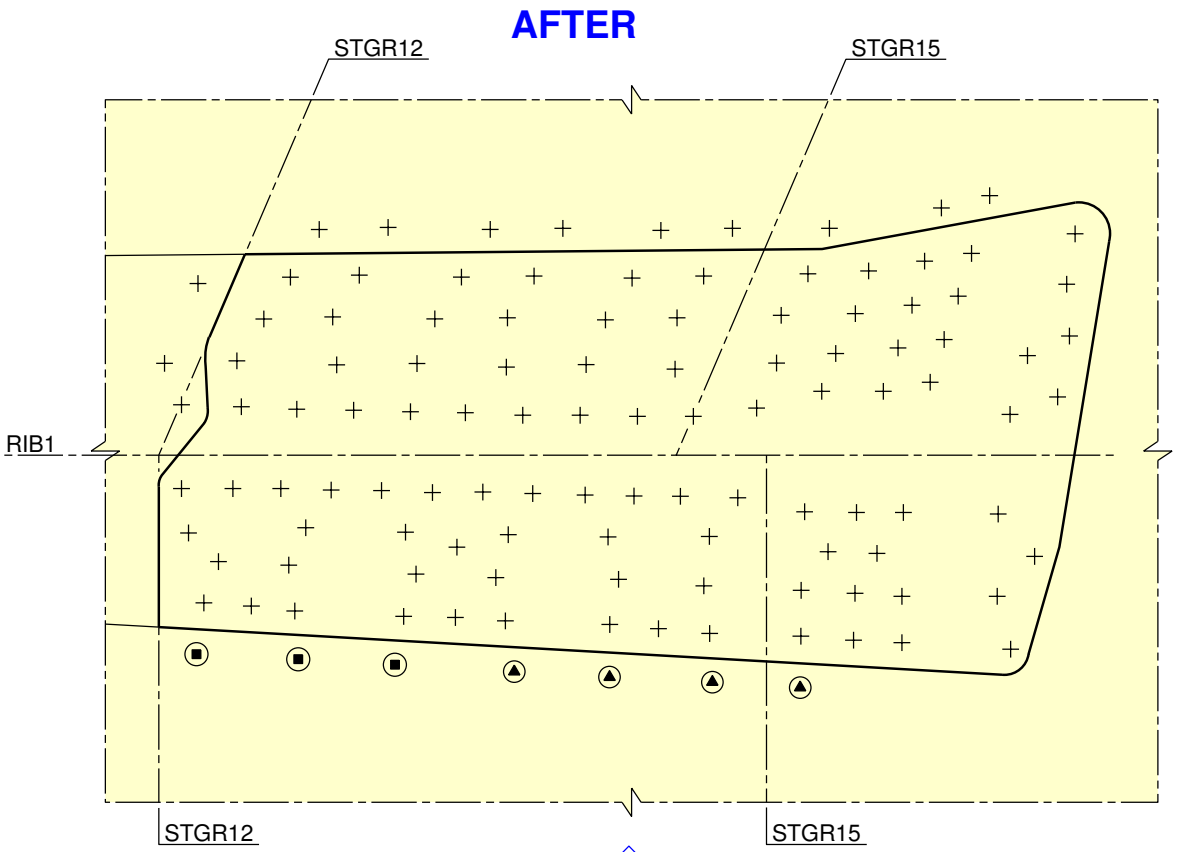
◔	(15) OR (79) (15)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CFAB_04_00

Figure A-FCFAB - Sheet 04
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002



HOLE	OLD ITEM
▲	13 OR 75 76
■	13 OR 74 76

+ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA.

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in).

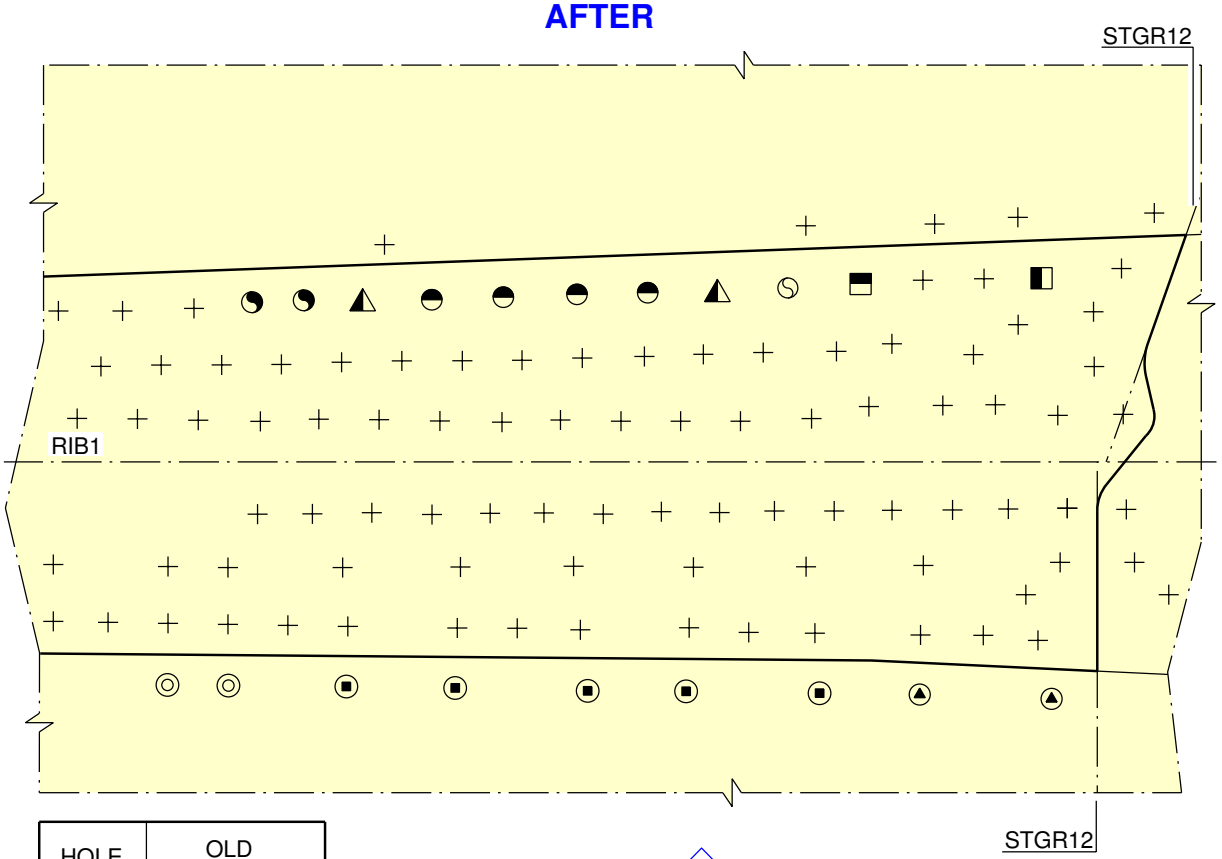
IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in).

N_SB_571131_5_CFAB_05_00

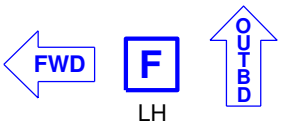
Figure A-FCFAB - Sheet 05
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

AFTER



HOLE	OLD ITEM
◓	10 OR 34 35
◭	10 OR 78 35
⦸	10 OR 82 35
◧	11 OR 37 44
⬒	11 OR 43 44
◎	13 OR 73 76
▲	13 OR 75 76
◉	13 OR 74 76



LH

ROTATED VIEW FOR A BETTER UNDERSTANDING

◔	15 OR 80 11

┼ FASTENERS NOT AFFECTED

NOTE :

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

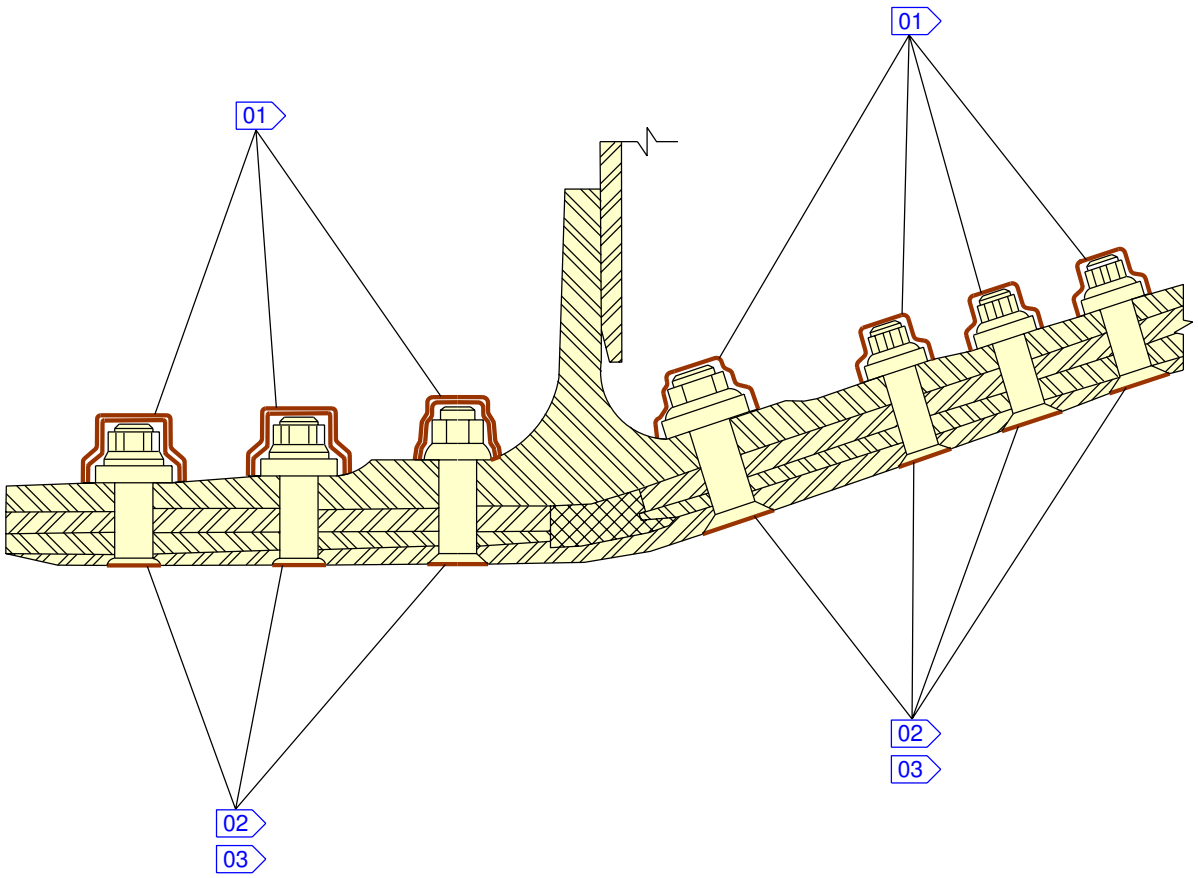
IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

N_SB_571131_5_CFAB_06_01

Figure A-FCFAB - Sheet 06
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

SEALING PRINCIPLE



A - A

NOTE:

01 APPLY MAT. No 06ABB1 AND MAT. No 06ABB1 ON THE NUTS

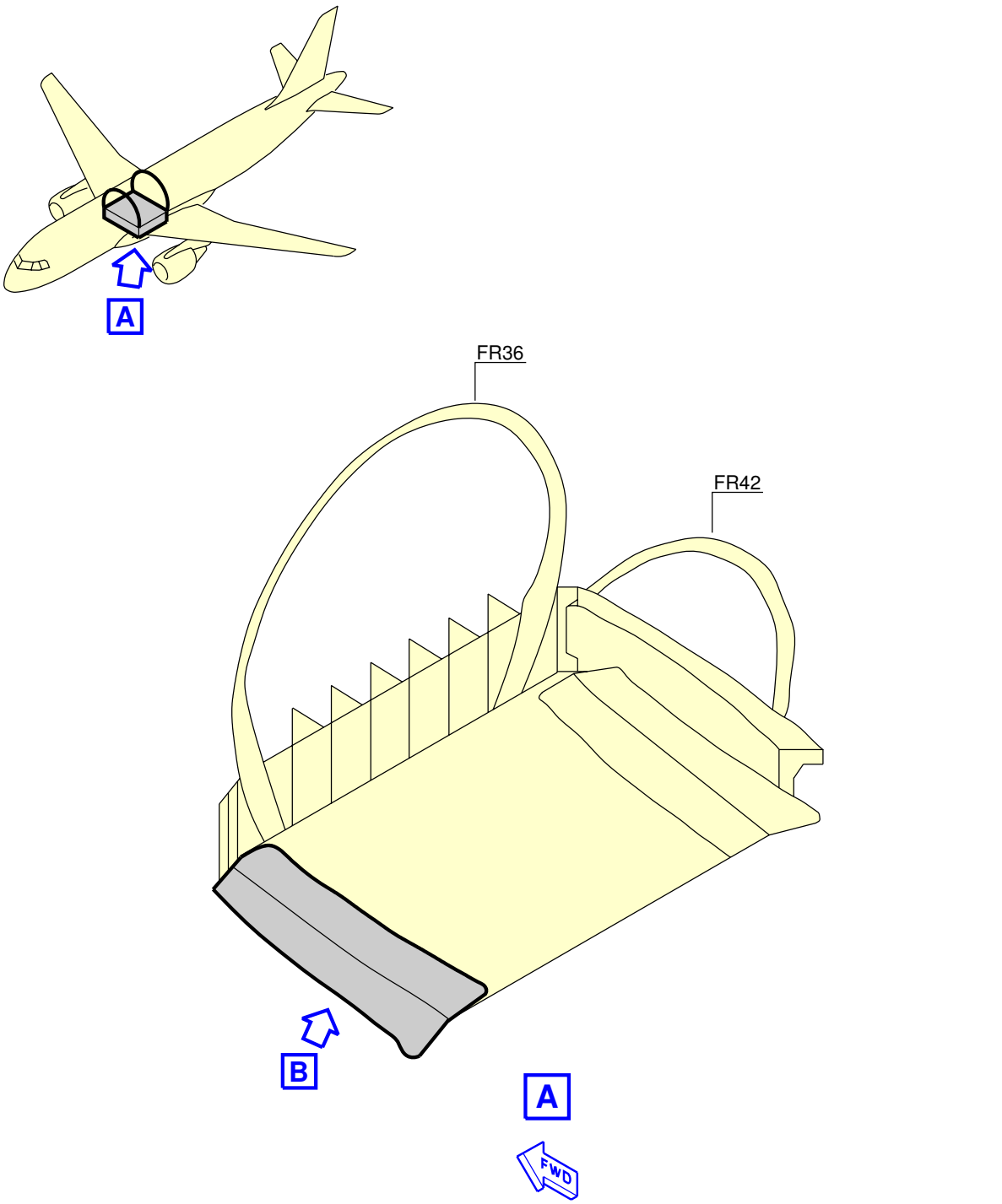
02 APPLY MAT. No 04EAC2, MAT. No 04CMA2 AND MAT. No 04JAA3 ON THE BOLTS

03 WET ASSEMBLY, APPLY MAT. No 06ABB1

N_SB_571131_5_CFAB_07_02

Figure A-FCFAB - Sheet 07
LH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

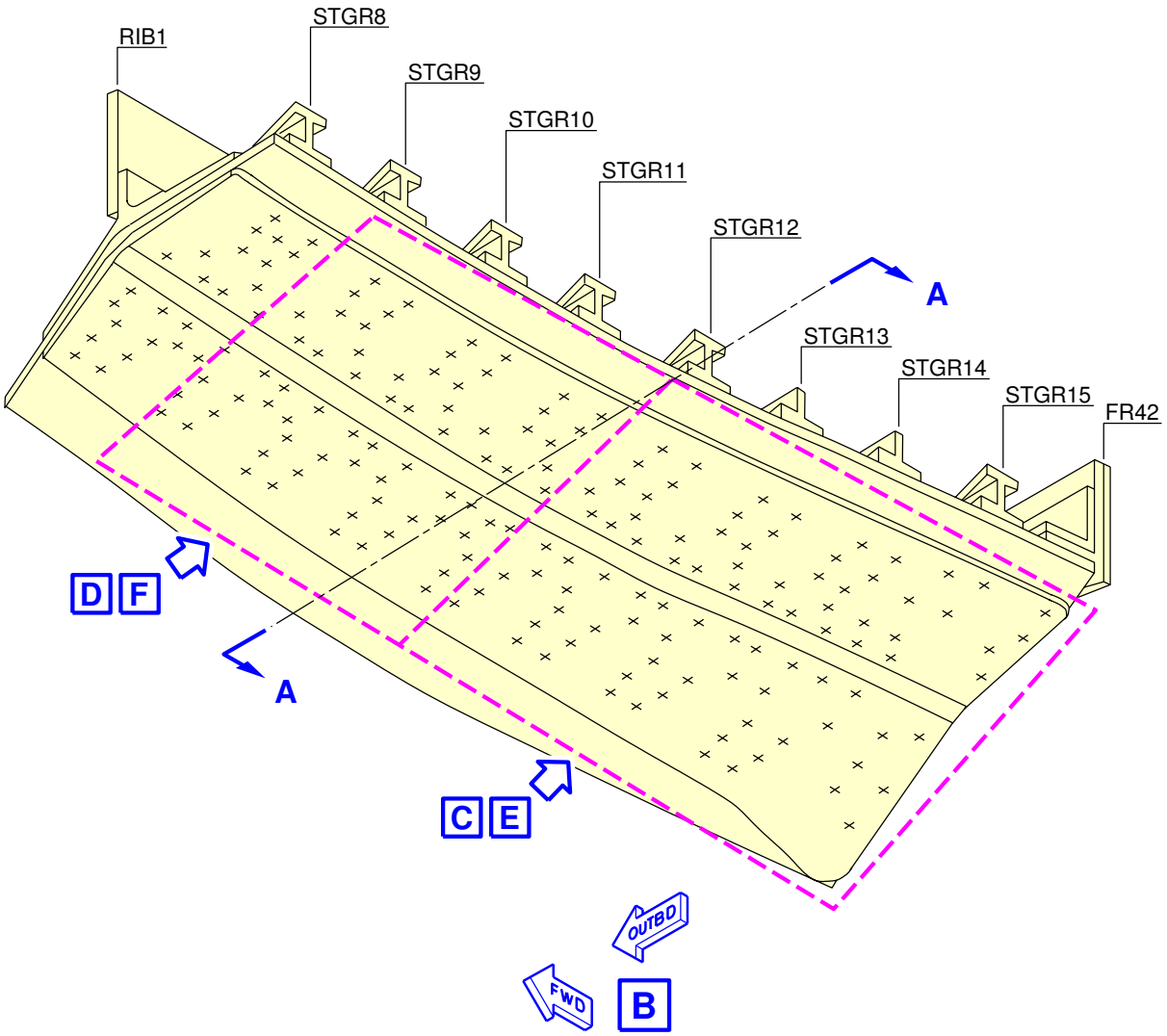
**CONF 001



N_SB_571131_5_CGAA_01_01

Figure A-FCGAA - Sheet 01
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

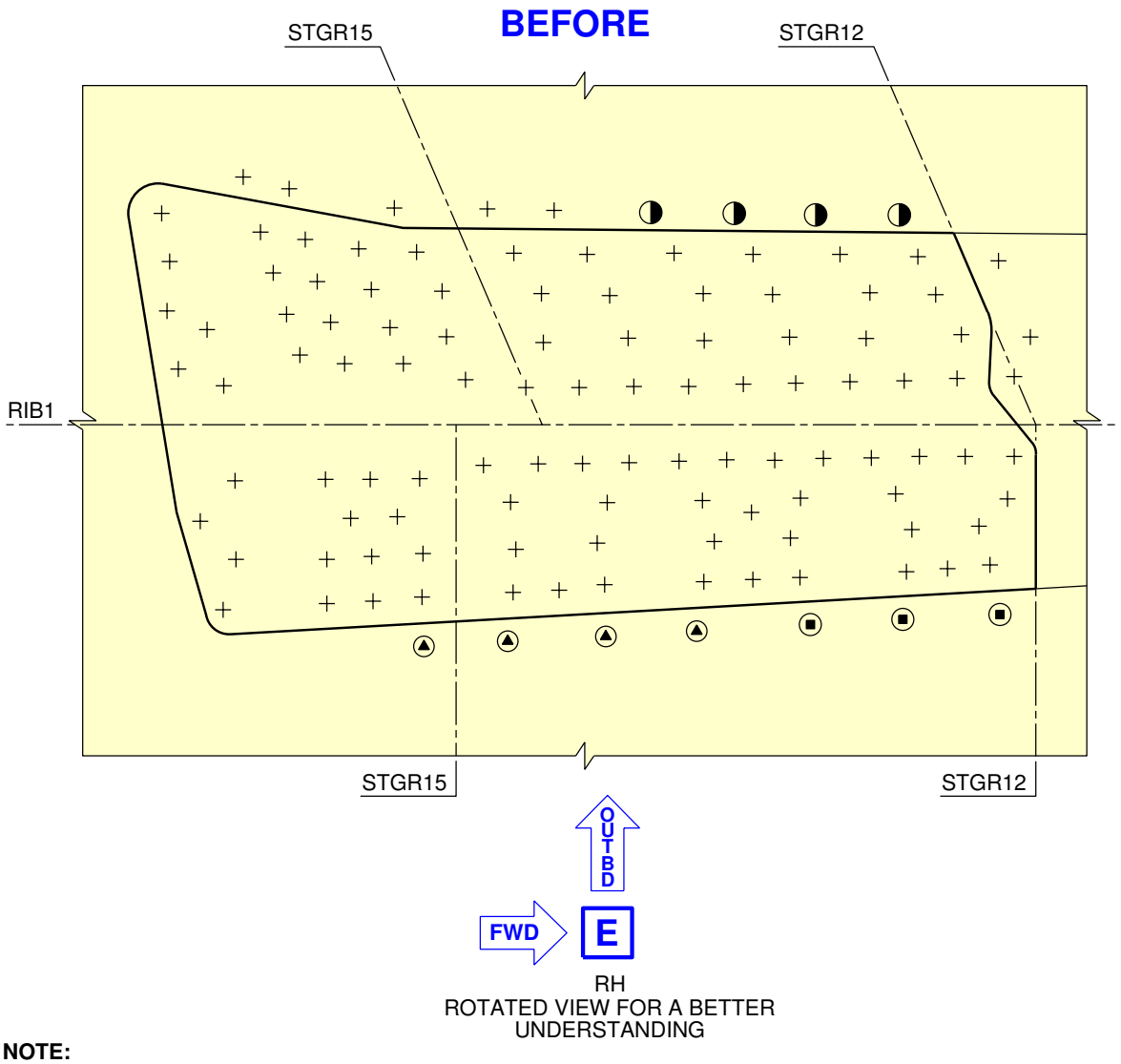


RH SHOWN

N_SB_571131_5_CGAA_02_00

Figure A-FCGAA - Sheet 02
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001



NOTE:

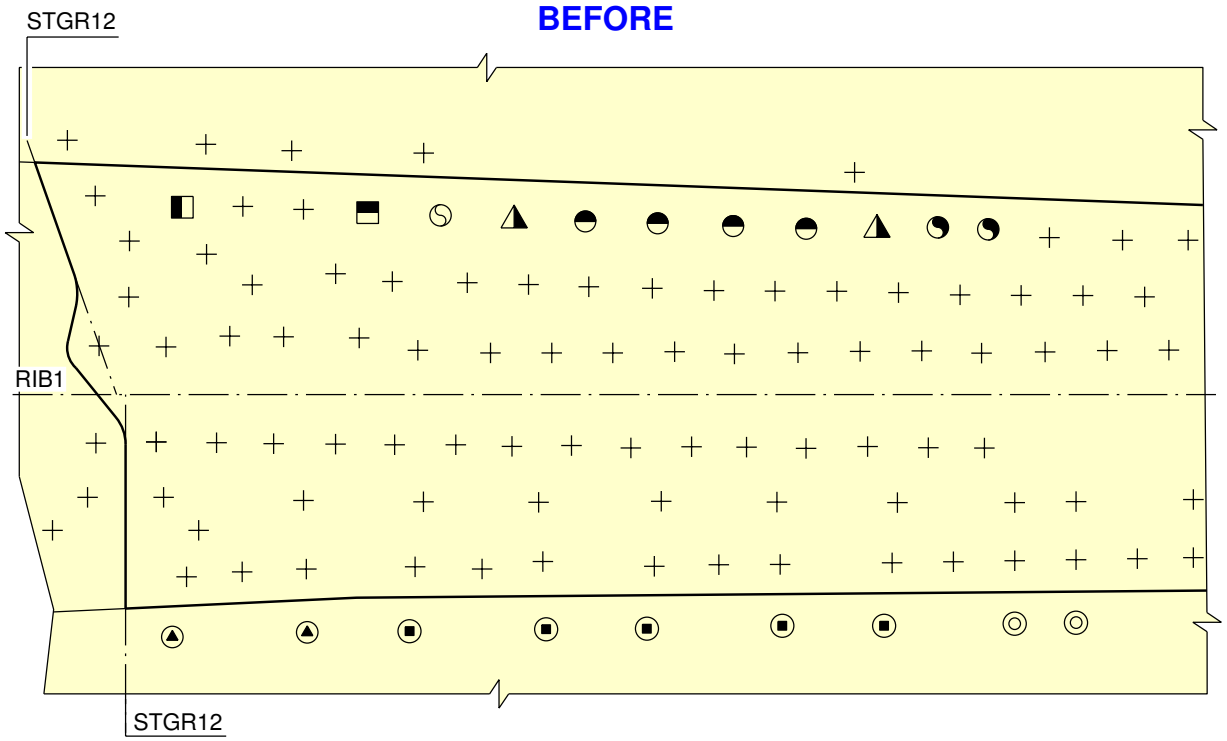
HOLE	OLD ITEM
◑	(10) OR (3) (10)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

+ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAA_03_01

Figure A-FCGAA - Sheet 03
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001



ROTATED VIEW FOR A BETTER UNDERSTANDING

NOTE:

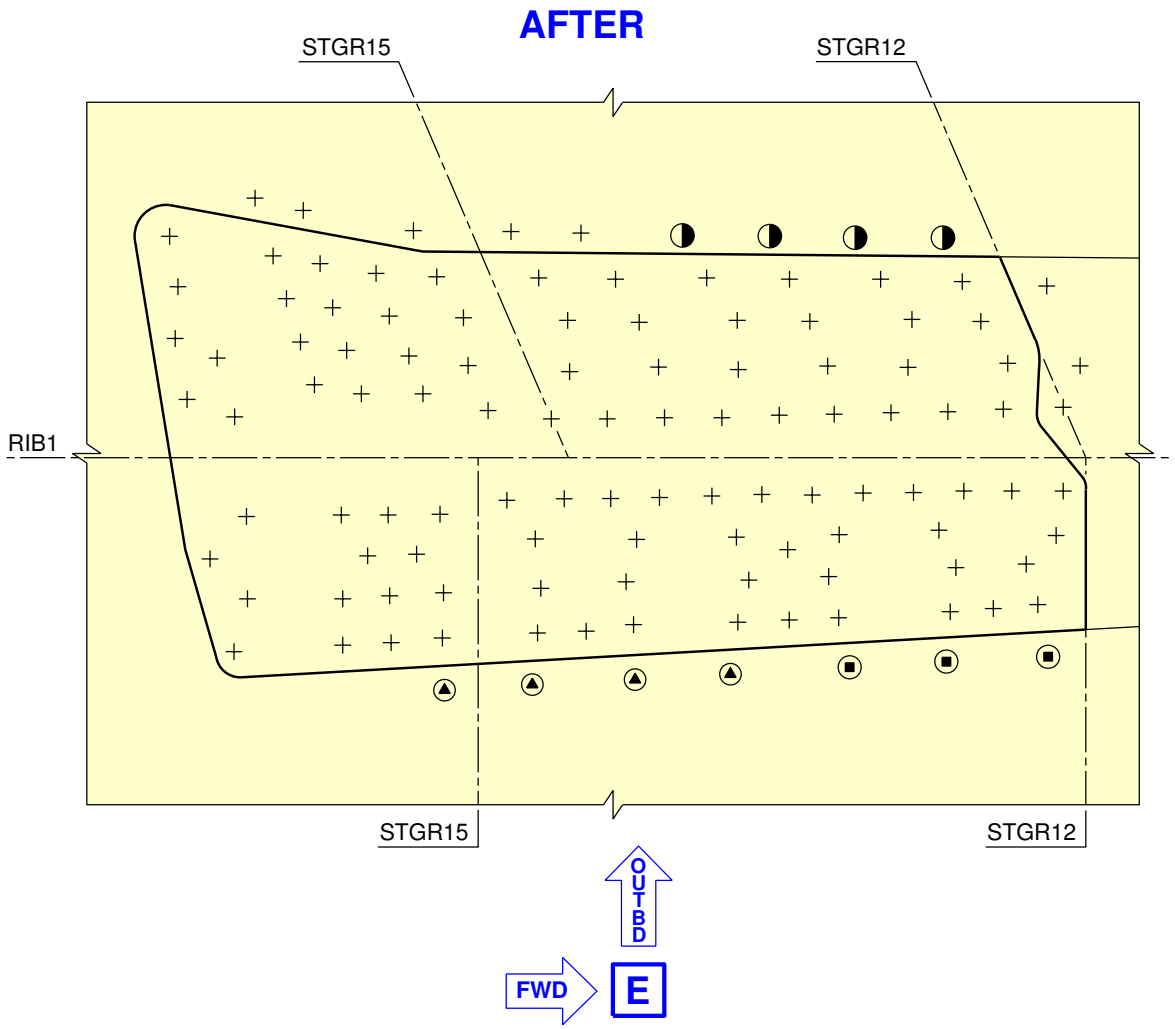
HOLE	OLD ITEM
◧	(11) OR (14) (11)
⬒	(11) OR (12) (11)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)
◎	(13) OR (70) (13)
◭	(10) OR (77) (10)
◓	(10) OR (7) (10)
⊘	(10) OR (81) (10)
◔	(13) OR (79) (15)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAA_04_01

Figure A-FCGAA - Sheet 04
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001



HOLE	OLD ITEM
◑	10 OR 32 35
▲	13 OR 75 76
■	13 OR 74 76

+ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

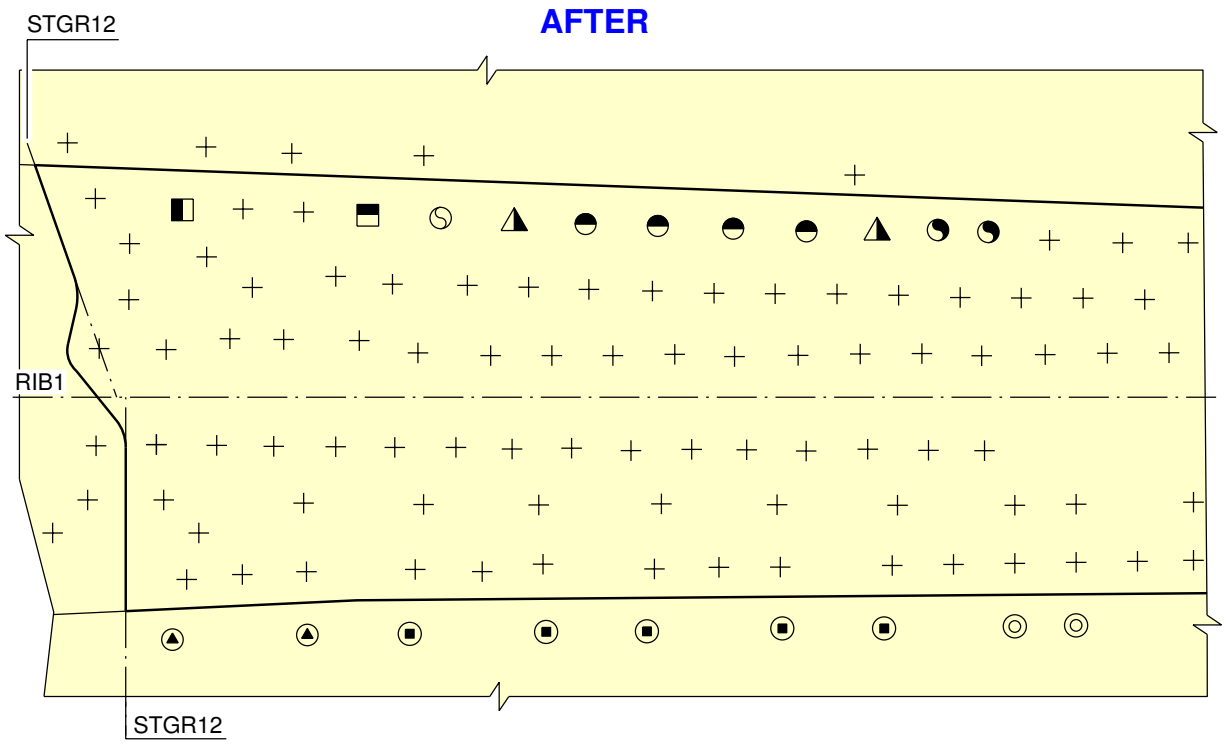
IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

N_SB_571131_5_CGAA_05_01

Figure A-FCGAA - Sheet 05
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001



HOLE	OLD ITEM
◧	11 OR 37 44
⬒	11 OR 43 44
▲	13 OR 75 76
■	13 OR 74 76

◎	13 OR 73 76
◭	10 OR 78 35

◓	10 OR 34 35
Ⓢ	10 OR 82 35
◔	15 OR 80 11

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

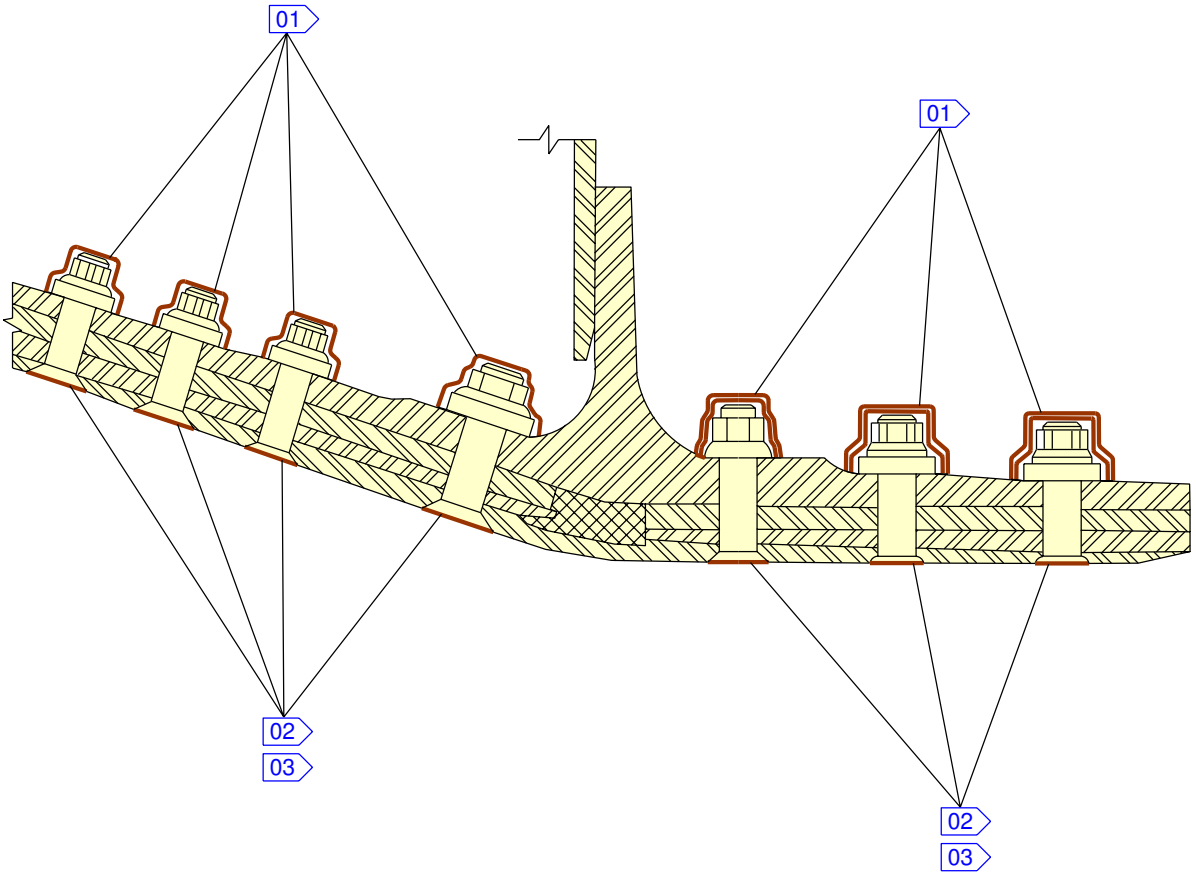
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAA_06_01

Figure A-FCGAA - Sheet 06
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 001

SEALING PRINCIPLE



A-A

NOTE:

01 APPLY MAT. No 06ABB1 AND MAT. No 06PAG1 ON THE NUTS

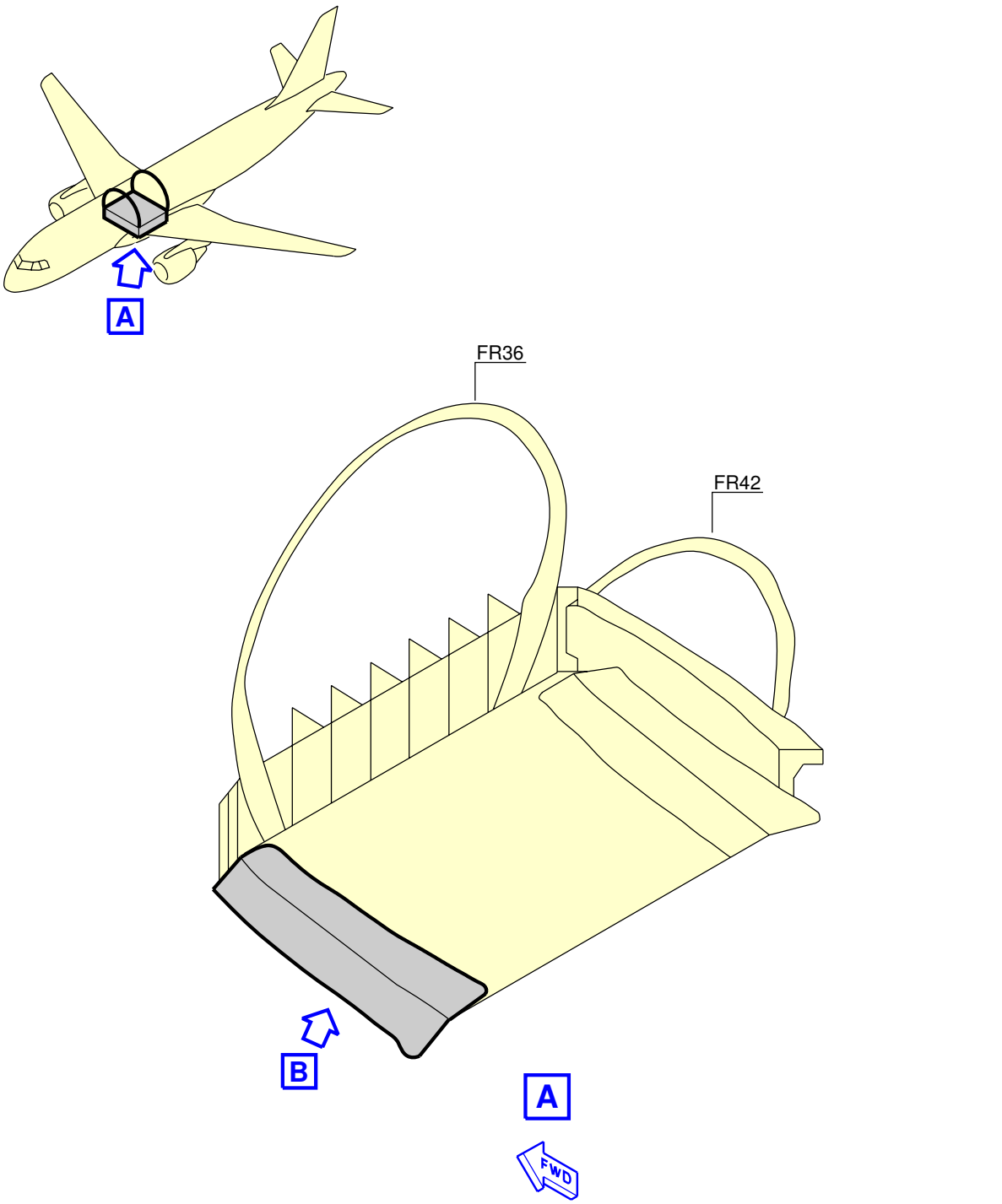
02 APPLY MAT. No 04EAC2, MAT. No 04CMA2 AND MAT. No 04JAA3 ON THE BOLTS

03 WET ASSEMBLY, APPLY MAT. No 06ABB1

N_SB_571131_5_CGAA_07_02

Figure A-FCGAA - Sheet 07
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

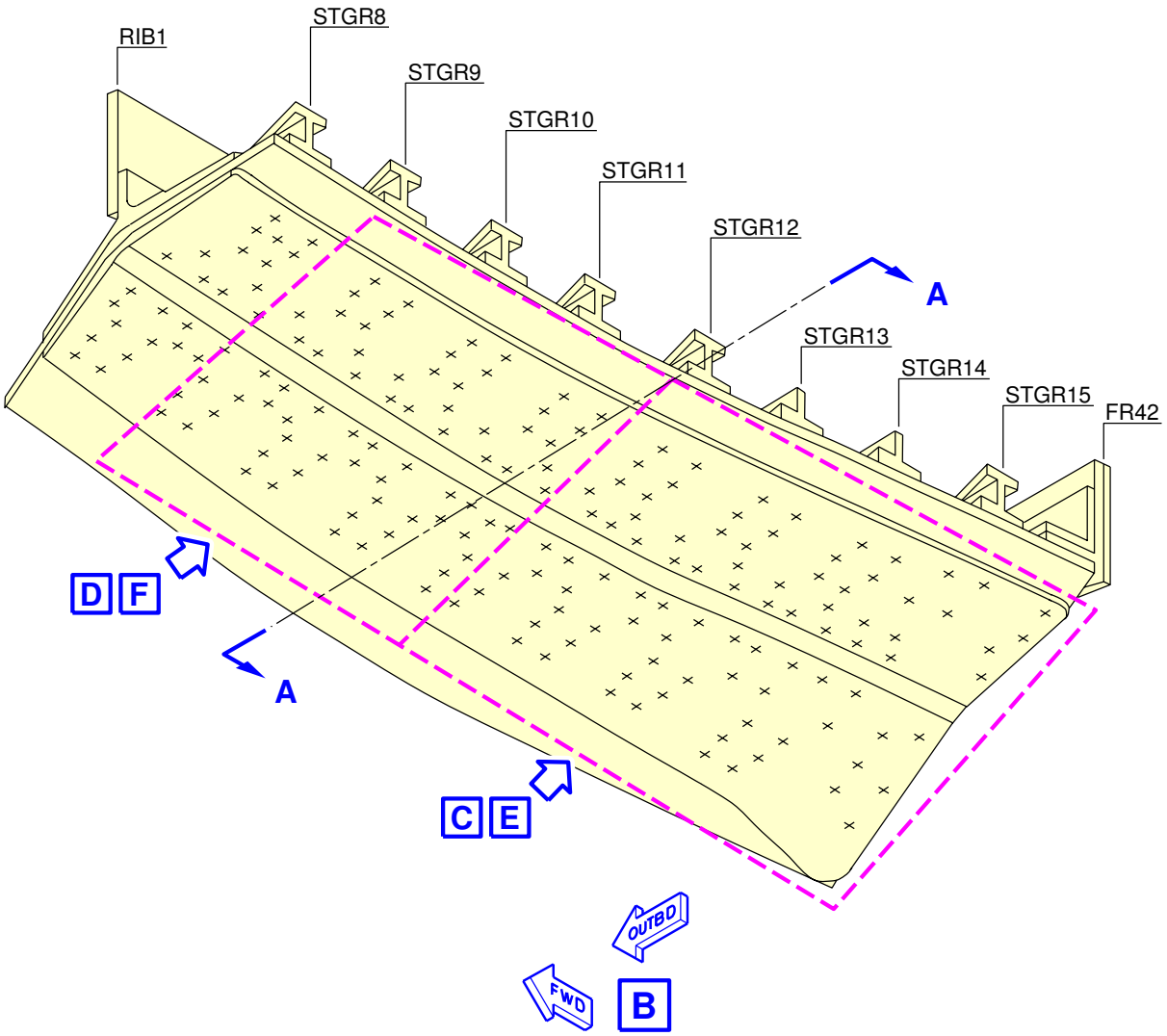
**CONF 002



N_SB_571131_5_CGAB_01_00

Figure A-FCGAB - Sheet 01
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

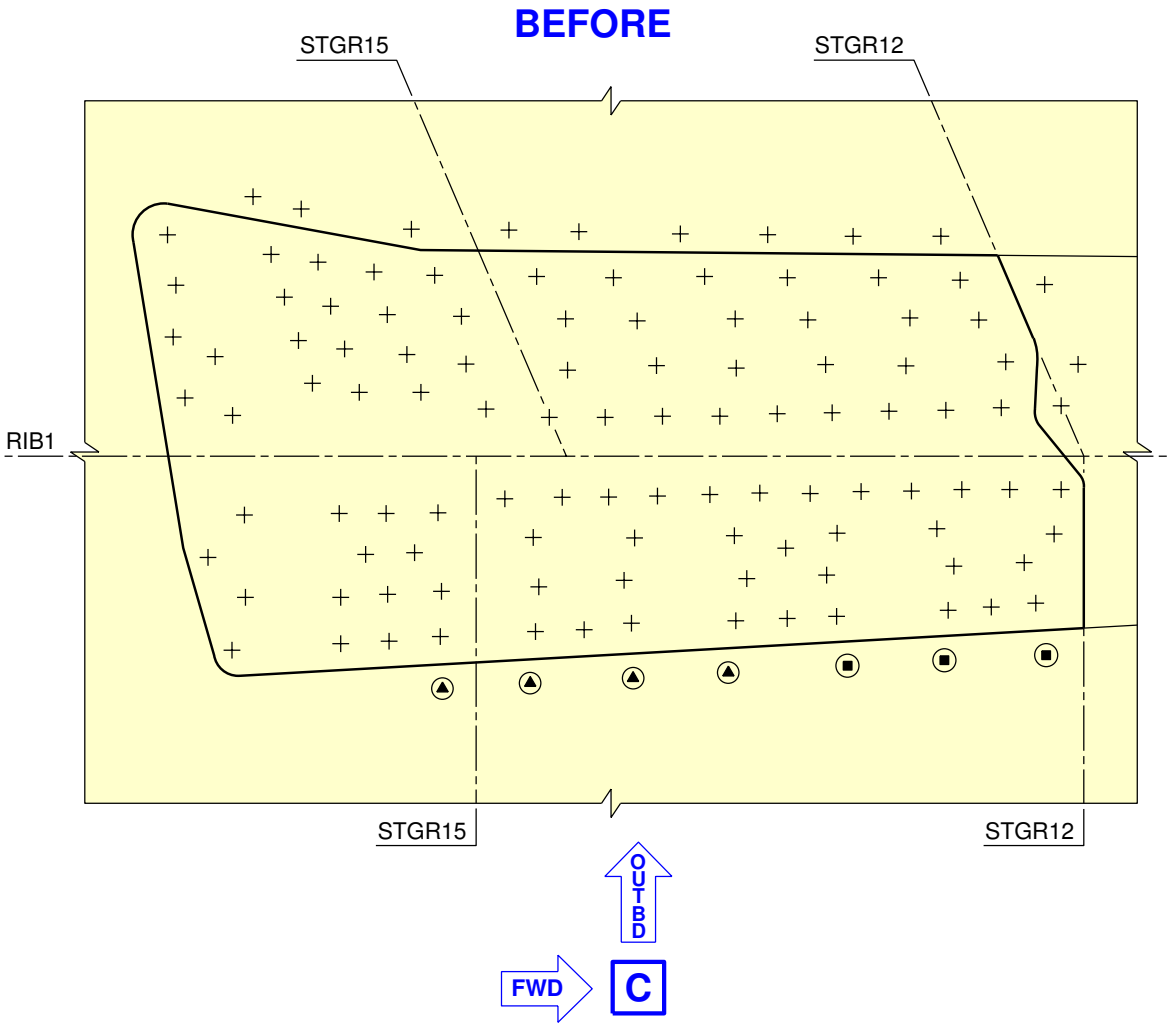


RH SHOWN

N_SB_571131_5_CGAB_02_00

Figure A-FCGAB - Sheet 02
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002



NOTE:

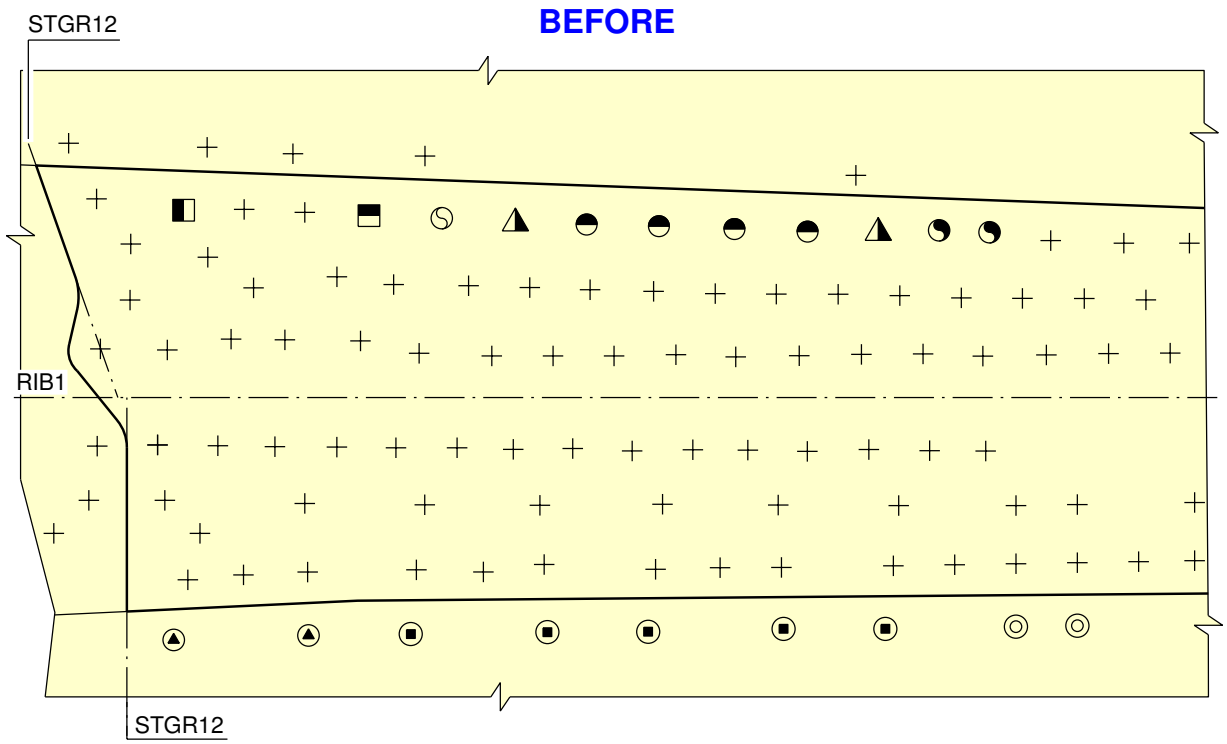
HOLE	OLD ITEM
▲	(13) OR (72) (13)
■	(13) OR (71) (13)

+ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAB_03_01

Figure A-FCGAB - Sheet 03
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002



ROTATED VIEW FOR A BETTER UNDERSTANDING

NOTE:

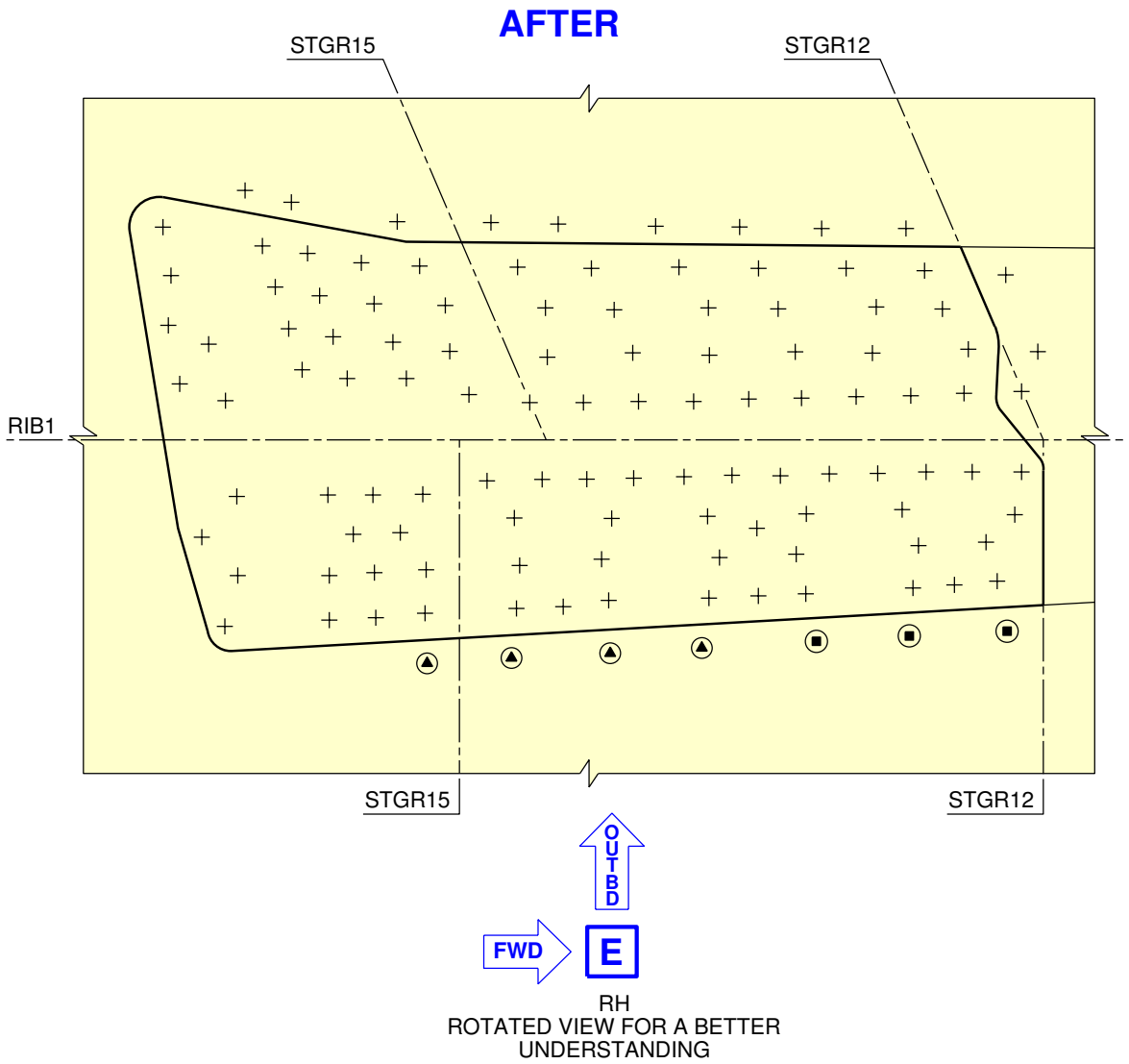
HOLE	OLD ITEM
◧	(11) OR (14) (11)
⬒	(11) OR (12) (11)
▲	(13) OR (72) (13)
■	(13) OR (71) (13)
◎	(13) OR (70) (13)
◭	(10) OR (77) (10)
◓	(10) OR (7) (10)
Ⓢ	(10) OR (81) (10)
◔	(13) OR (79) (15)

┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAB_04_01

Figure A-FCGAB - Sheet 04
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002



HOLE	OLD ITEM
▲	13 OR 75 76
■	13 OR 74 76

+ FASTENERS NOT AFFECTED

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

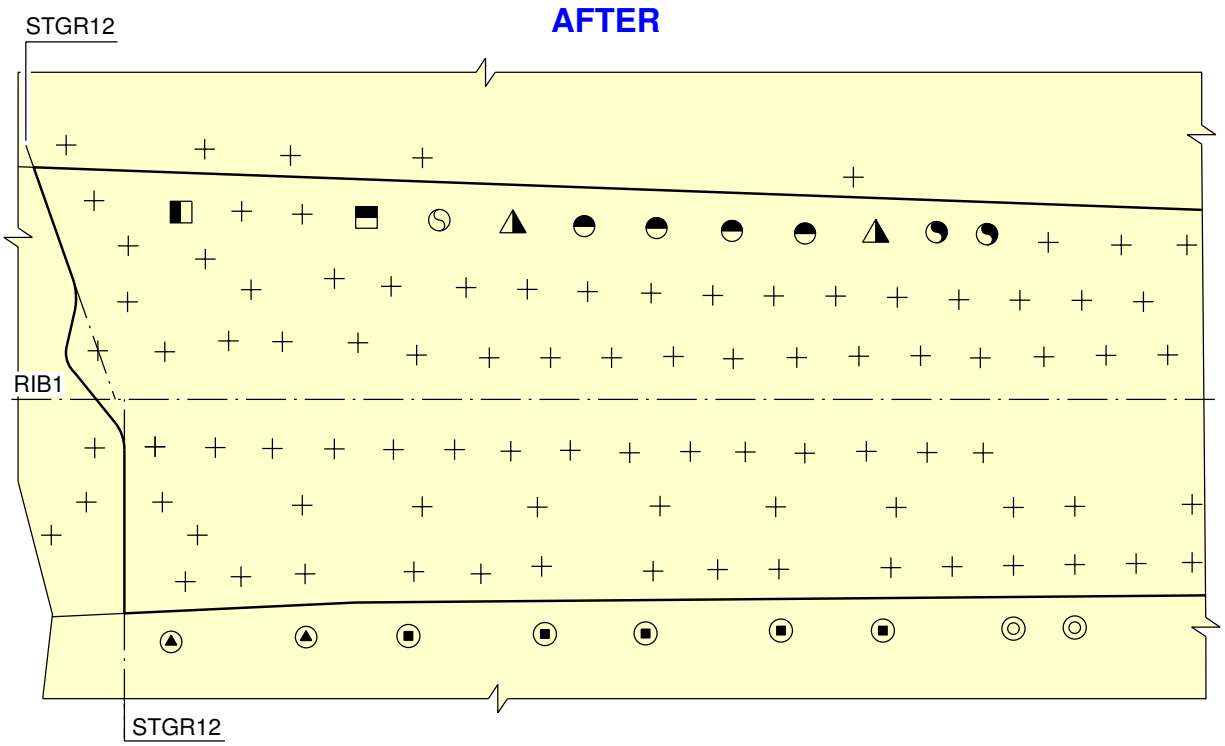
IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

N_SB_571131_5_CGAB_05_01

Figure A-FCGAB - Sheet 05
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002



HOLE	OLD ITEM
◧	11 OR 37 44
⬒	11 OR 43 44
▲	13 OR 75 76
■	13 OR 74 76

◎	13 OR 73 76
◭	10 OR 78 35

◓	10 OR 34 35
Ⓢ	10 OR 82 35
◔	15 OR 80 11

NOTE:

FOR THE INSTALLATION OF THE FASTENERS, SEE THE DEFINITION OF THE WASHER THICKNESS REFER TO FIG. A–FCCAA OR FIG. A–FCDAA

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT, TORQUE THE NUT BETWEEN 3.80 daN AND 4.60 daN (342 lbf.in AND 411 lbf.in)

IN THE CASE OF THE ONLY REPLACEMENT OF THE NUT AND THE SCREW, TORQUE THE NUT BETWEEN 5.60 daN AND 6.70 daN (493 lbf.in AND 592 lbf.in)

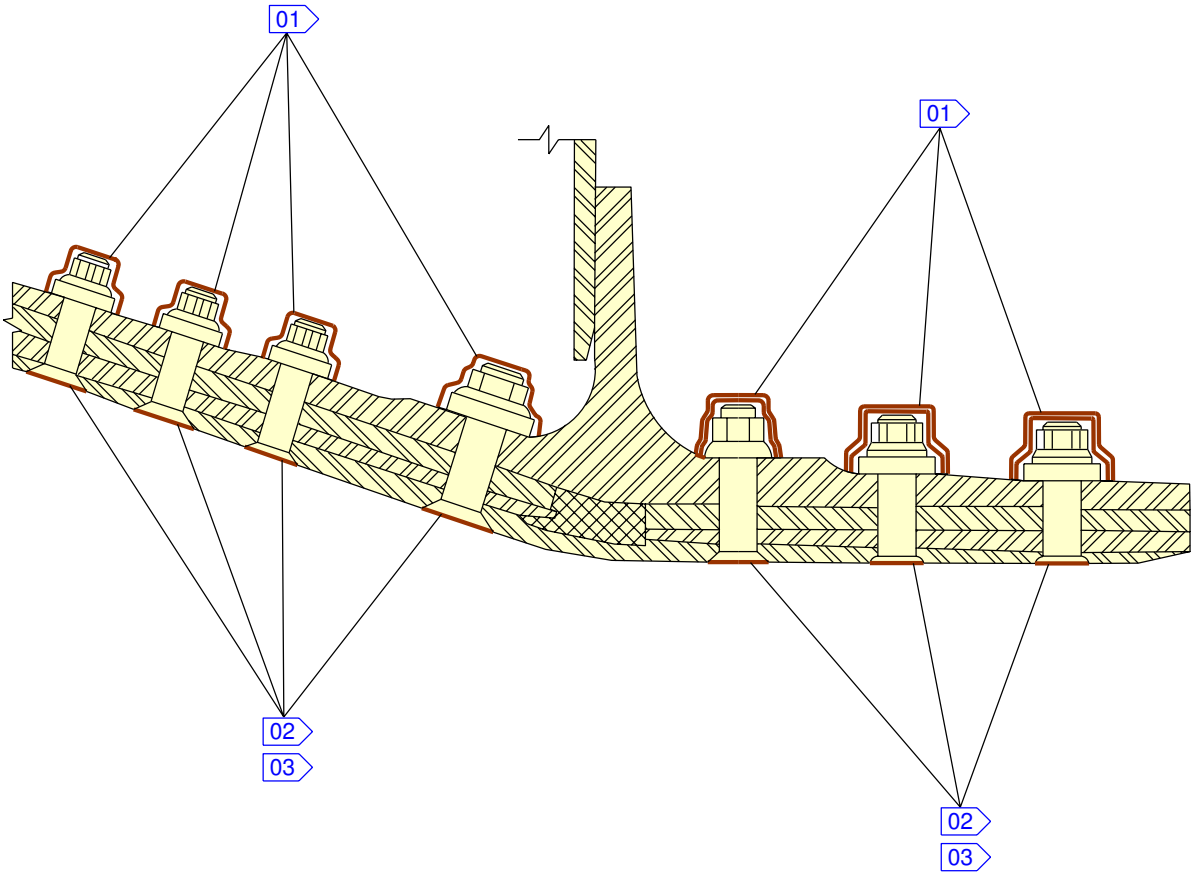
┼ FASTENERS NOT AFFECTED

N_SB_571131_5_CGAB_06_01

Figure A-FCGAB - Sheet 06
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF 002

SEALING PRINCIPLE



A-A

NOTE:

01 APPLY MAT. No 06ABB1 AND MAT. No 06PAG1 ON THE NUTS

02 APPLY MAT. No 04EAC2, MAT. No 04CMA2 AND MAT. No 04JAA3 ON THE BOLTS

03 WET ASSEMBLY, APPLY MAT. No 06ABB1

N_SB_571131_5_CGAB_07_02

Figure A-FCGAB - Sheet 07
RH Side, Replacement of the Lower Panel Fasteners for the ADDITIONAL WORK

**CONF ALL

INSPECTION REPORT

SERVICE BULLETIN No. : A320–57–1131	RETURN TO :
A/C MSN :	AIRBUS CUSTOMER SERVICES ENGINEERING DOORS – FUSELAGE – CWB – WINDOWS 1 ROND POINT MAURICE BELLONTE 31707 BLAGNAC CEDEX FRANCE FAX +33 (0)5 61 93 36 14 E–mail: inspection.results@airbus.com
FLIGHT CYCLES :	
FLIGHT HOURS :	
DATE OF INSPECTION :	
FINDINGS : YES ☐ NO ☐	
INSPECTION METHOD : ☐ DETAILED INSPECTION	

CENTER WING BOX (CWB)

SIDE	GAGE DOESN'T FIT OR FITS WITHOUT MOVEMENT				
	☐ YES		☐ NO		
	THREAD NOT DAMAGED	THREAD DAMAGED	THREAD MARKS FOUND	THREAD NOT DAMAGED	THREAD DAMAGED
LH					
RH					

WING

SIDE	GAGE DOESN'T FIT OR FITS WITHOUT MOVEMENT				
	☐ YES		☐ NO		
	THREAD DAMAGED	THREAD NOT DAMAGED	THREAD MARKS FOUND	THREAD DAMAGED	THREAD NOT DAMAGED
LH					
RH					

PLEASE PRECISE OTHER FINDINGS :

N_SB_571131_5_RAAA_01_00

Figure A-FRAAA - Sheet 01
Inspection Report

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**CONF ALL

(1) Weight Variant (WV) correspondence table

SERIES	AIRCRAFT MODEL	WEIGHT VARIANT (WV)	ASSOCIATED MODIFICATION	ASSOCIATED SERVICE BULLETIN
A320-200	A320-211 A320-212 A320-231	000		
		001	20966	SB A320-00-1002 OR SB A320-00-1003
		002	21601	
		003	22269	SB A320-00-1006
		004	21532	
		005	21711	SB A320-00-1178
		006	22436	
		007	23264	SB A320-00-1013
		008	23900	SB A320-00-1030
		009	23900 , 22269	SB A320-00-1006 OR SB A320-00-1030
		010	23900 , 23264	SB A320-00-1013 OR SB A320-00-1030
		011	30307	SB A320-00-1077
		012	30479	SB A320-00-1069 OR SB A320-00-1227
		013	31132	SB A320-00-1060
		014	31385	SB A320-00-1063

SERIES	AIRCRAFT MODEL	WEIGHT VARIANT (WV)	ASSOCIATED MODIFICATION	ASSOCIATED SERVICE BULLETIN
A320-200	A320-214 A320-232 A320-233	000		
		002	21601	
		003	22269	SB A320-00-1006
		007	23264	SB A320-00-1013
		008	23900	SB A320-00-1030
		009	23900 , 22269	SB A320-00-1006 OR SB A320-00-1030
		010	23900 , 23264	SB A320-00-1013 OR SB A320-00-1030
		011	30307	SB A320-00-1077
		012	30479	SB A320-00-1069 OR SB A320-00-1227
		013	31132	SB A320-00-1060
		014	31385	SB A320-00-1063
		015	34047	SB A320-00-1126
		016	34094	SB A320-00-1143

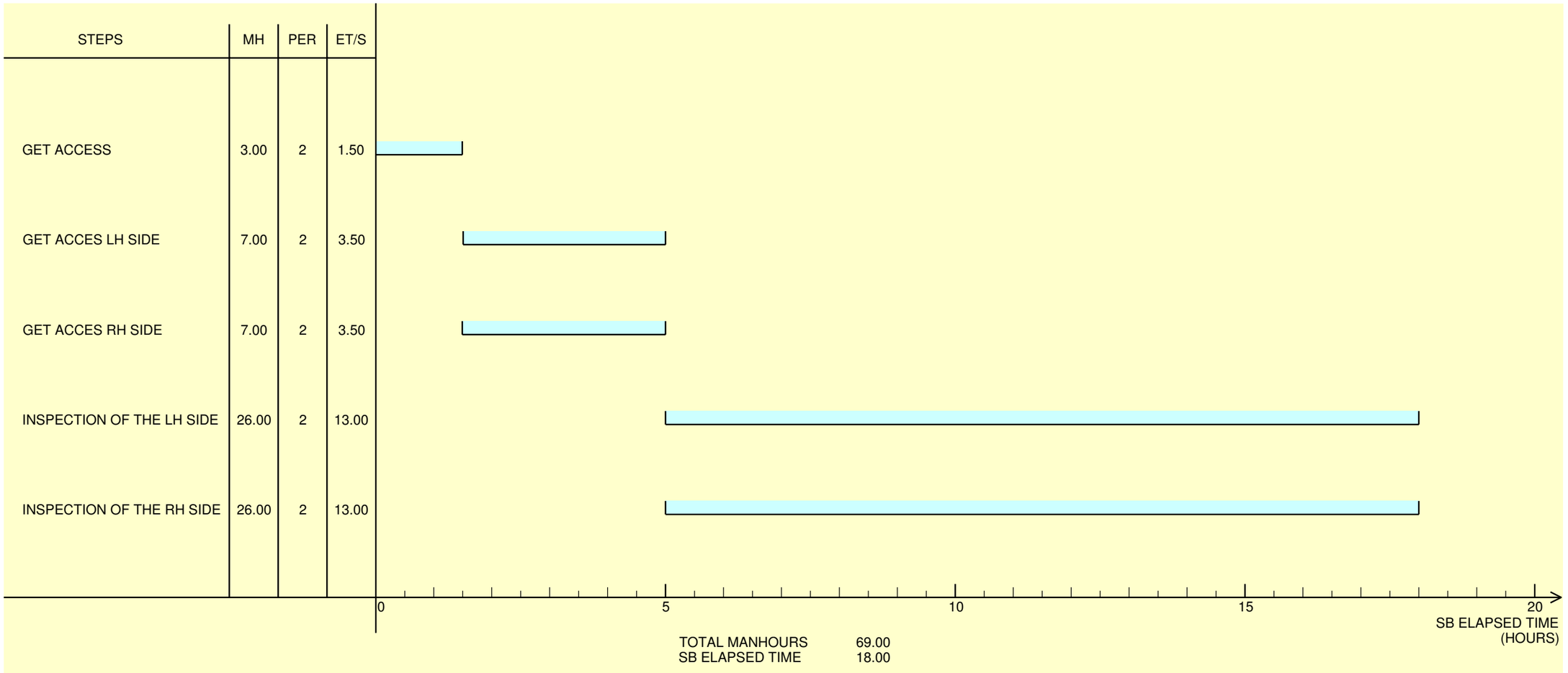
**CONF ALL

(1) For an explanation of the manhours and elapsed time, refer to the following Gantt Chart.

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
GET ACCESS	3.00	2	1.50
GET ACCES LH SIDE	7.00	2	3.50
GET ACCES RH SIDE	7.00	2	3.50
INSPECTION OF THE LH SIDE	26.00	2	13.00
INSPECTION OF THE RH SIDE	26.00	2	13.00



TOTAL MANHOURS 69.00
SB ELAPSED TIME 18.00

NOTE:

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS
ARE NOT REFLECTED IN THIS GANTT CHART

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

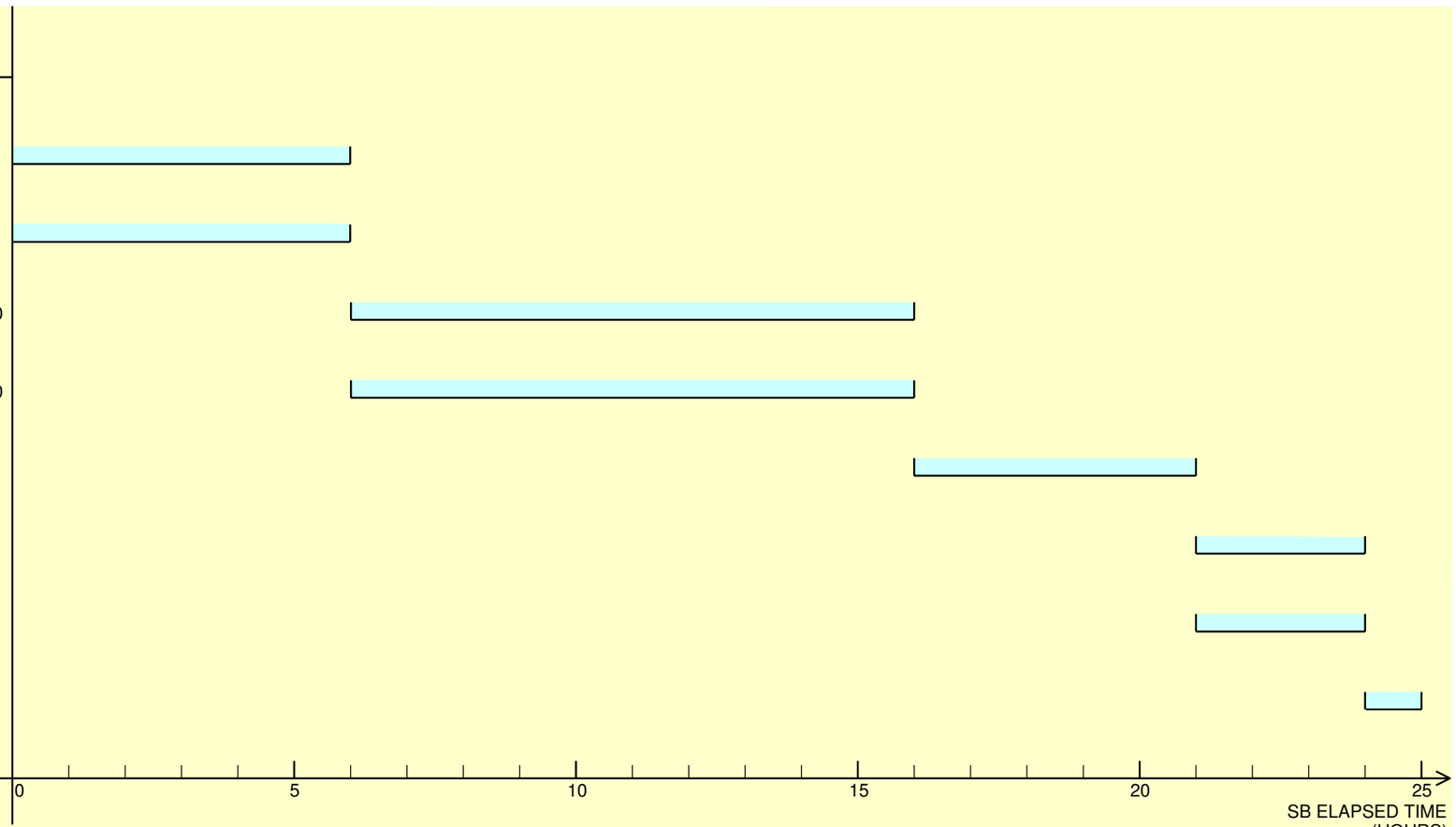
N_SB_571131_5_ABAA_01_04

Figure A-FABAA - Sheet 01
Gantt Chart Inspection Task

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
REPLACEMENT OF THE NUT ON LH SIDE	12.00	2	6.00
REPLACEMENT OF THE NUT ON RH SIDE	12.00	2	6.00
REPLACEMENT OF THE TAPERLOK ON THE LH SIDE (FOR ONE TAPERLOK)	16.00	2	10.00
REPLACEMENT OF THE TAPERLOK ON THE RH SIDE (FOR ONE TAPERLOK)	16.00	2	10.00
TEST	5.00	1	5.00
CLOSE–UP LH SIDE	6.00	2	3.00
CLOSE–UP RH SIDE	6.00	2	3.00
CLOSE–UP	2.50	2	1.00



TOTAL MANHOURS 75.50
SB ELAPSED TIME 25.00

NOTE:

01 THIS CHART IS ONLY A PROPOSAL
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS
ARE NOT REFLECTED IN THIS GANTT CHART

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

N_SB_571131_5_ACAA_01_02

Figure A-FACAA - Sheet 01
Gantt Chart Repair Task

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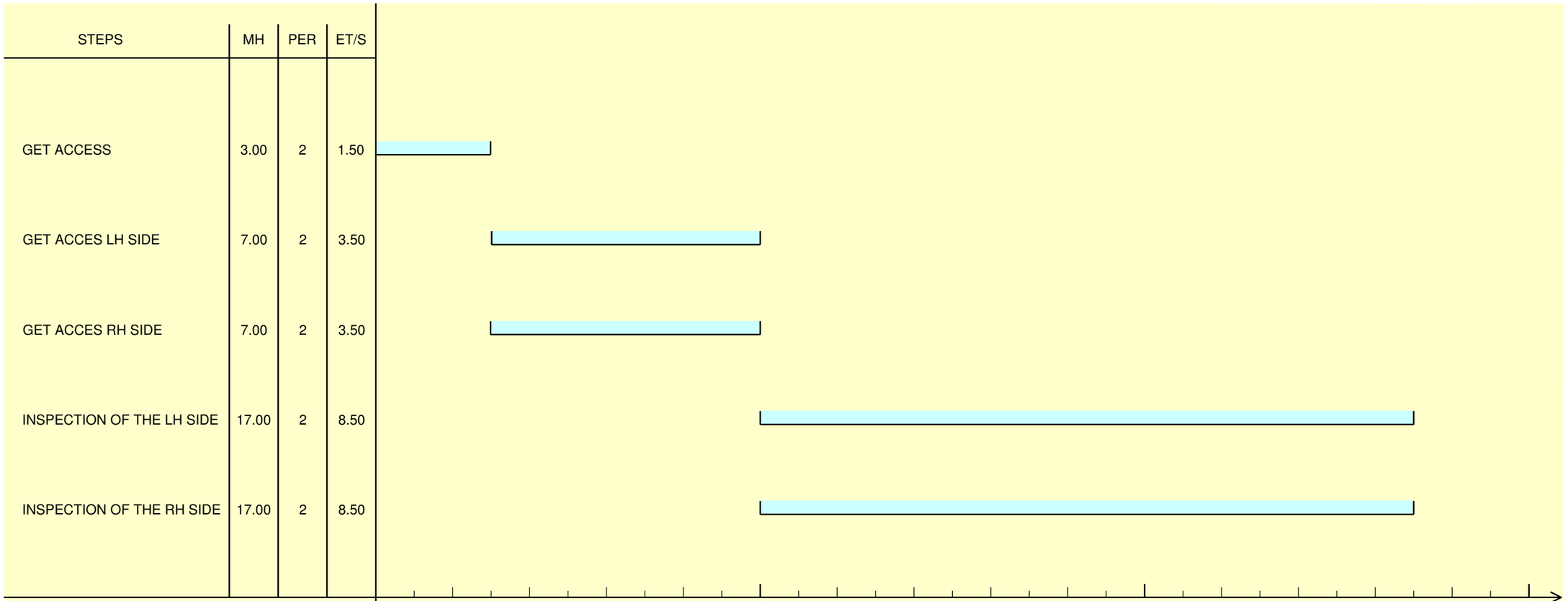
**CONF ALL

(1) For an explanation of the manhours and elapsed time, refer to the following Gantt Chart.

**CONF 001

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
GET ACCESS	3.00	2	1.50
GET ACCES LH SIDE	7.00	2	3.50
GET ACCES RH SIDE	7.00	2	3.50
INSPECTION OF THE LH SIDE	17.00	2	8.50
INSPECTION OF THE RH SIDE	17.00	2	8.50



TOTAL MANHOURS 51.00
SB ELAPSED TIME 13.50

NOTE:

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

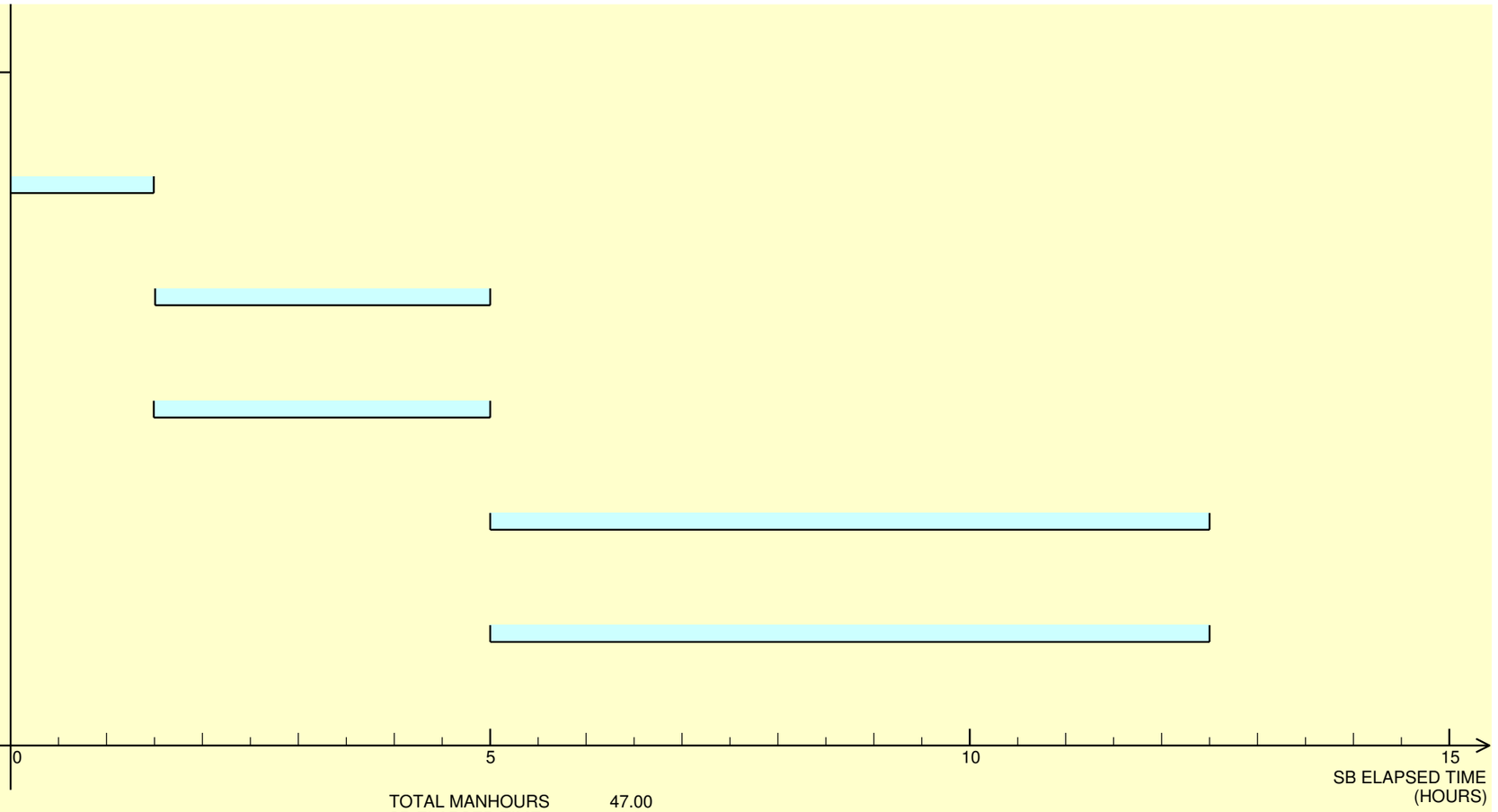
N_SB_571131_5_ADAA_01_01

Figure A-FADAA - Sheet 01
Gantt Chart Inspection Task for ADDITIONAL WORK

**CONF 002

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
GET ACCESS	3.00	2	1.50
GET ACCES LH SIDE	7.00	2	3.50
GET ACCES RH SIDE	7.00	2	3.50
INSPECTION OF THE LH SIDE	15.00	2	7.50
INSPECTION OF THE RH SIDE	15.00	2	7.50



TOTAL MANHOURS 47.00
SB ELAPSED TIME 12.50

NOTE:

01 THIS CHART IS ONLY A PROPOSAL
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS
ARE NOT REFLECTED IN THIS GANTT CHART

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

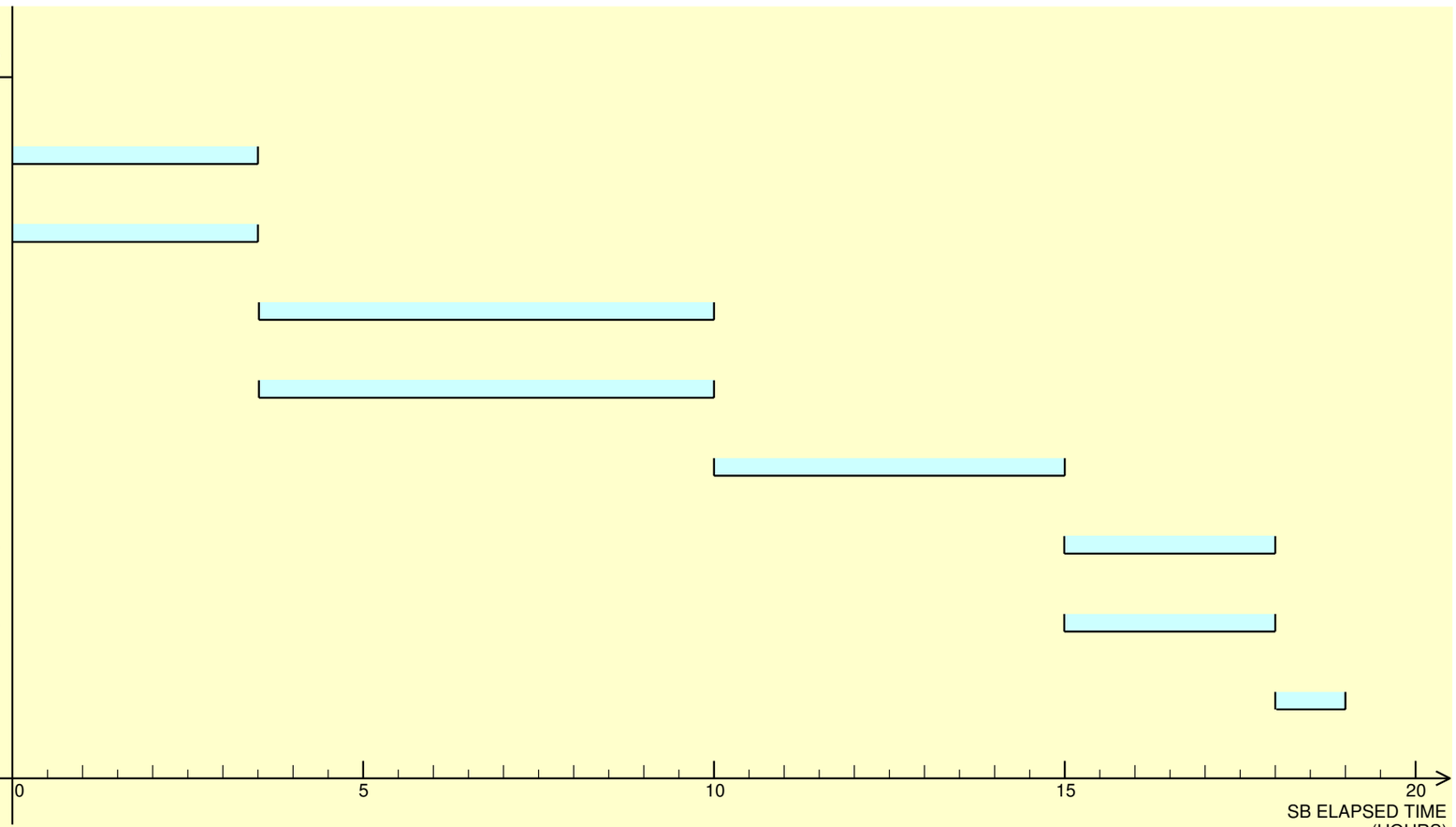
N_SB_571131_5_ADAB_01_00

Figure A-FADAB - Sheet 01
Gantt Chart Inspection Task for ADDITIONAL WORK

**CONF 001

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
REPLACEMENT OF THE NUT ON LH SIDE	7.00	2	3.50
REPLACEMENT OF THE NUT ON RH SIDE	7.00	2	3.50
REPLACEMENT OF THE TAPERLOK ON THE LH SIDE (FOR ONE TAPERLOK)	10.00	2	6.50
REPLACEMENT OF THE TAPERLOK ON THE RH SIDE (FOR ONE TAPERLOK)	10.00	2	6.50
TEST	5.00	1	5.00
CLOSE–UP LH SIDE	6.00	2	3.00
CLOSE–UP RH SIDE	6.00	2	3.00
CLOSE–UP	2.50	2	1.00



TOTAL MANHOURS 53.50
SB ELAPSED TIME 19.00

NOTE:

01 THIS CHART IS ONLY A PROPOSAL
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS
ARE NOT REFLECTED IN THIS GANTT CHART

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

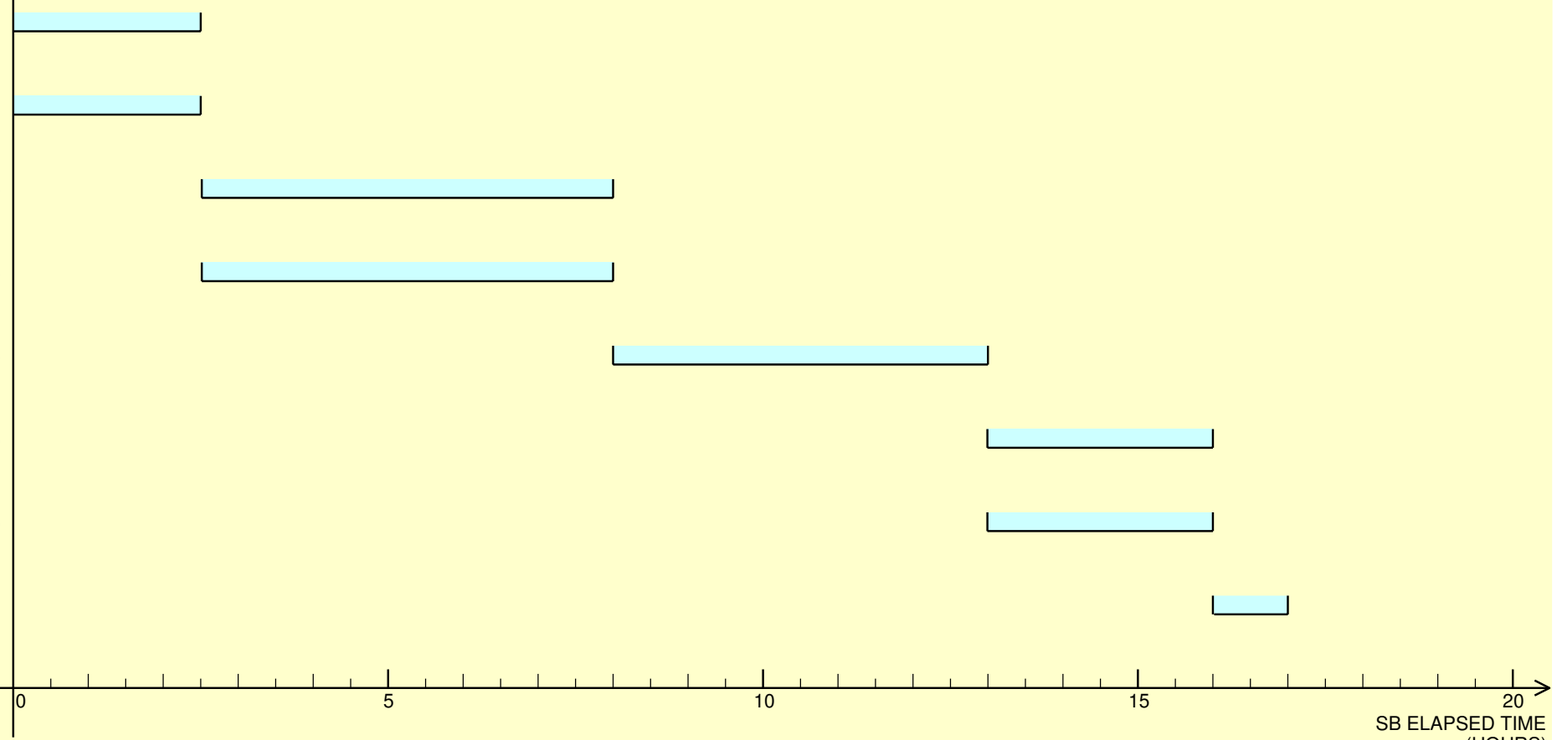
N_SB_571131_5_AEAA_01_01

Figure A-FAEAA - Sheet 01
Gantt Chart Repair Task for ADDITIONAL WORK

**CONF 002

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–57–1131 01 02

STEPS	MH	PER	ET/S
REPLACEMENT OF THE NUT ON LH SIDE	5.00	2	2.50
REPLACEMENT OF THE NUT ON RH SIDE	5.00	2	2.50
REPLACEMENT OF THE TAPERLOK ON THE LH SIDE (FOR ONE TAPERLOK)	8.00	2	5.50
REPLACEMENT OF THE TAPERLOK ON THE RH SIDE (FOR ONE TAPERLOK)	8.00	2	5.50
TEST	5.00	1	5.00
CLOSE–UP LH SIDE	6.00	2	3.00
CLOSE–UP RH SIDE	6.00	2	3.00
CLOSE–UP	2.50	2	1.00



TOTAL MANHOURS 45.50
SB ELAPSED TIME 17.00

NOTE:

01 THIS CHART IS ONLY A PROPOSAL
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS
ARE NOT REFLECTED IN THIS GANTT CHART

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

N_SB_571131_5_AEAB_01_00

Figure A-FAEAB - Sheet 01
Gantt Chart Repair Task for ADDITIONAL WORK

SERVICE BULLETIN
REPORTING SHEET

TITLE: WINGS - GENERAL - ONE TIME INSPECTION OF TAPERLOK BOLT AT WING TO FUSELAGE JUNCTION.

MODIFICATION No.: None

Please complete the appropriate item (A or B):
A - SB WILL BE embodied YES/NO (if NO please comment)
If YES, aircraft concerned (as per SB effectivity by default) and planned dates (month/year) of embodiment:

B - SB HAS BEEN embodied on aircraft:

Operator comments:

From Airline:
Name/Title:
Signature: Date:

If operational documentation is affected (see Paragraph 1.K of this SB): If information is needed prior to next normal revision or prior to SB embodiment, please indicate required service(s):
Either: Modification Operational Impact (MOI), if available YES/NO
Or : Intermediate revision YES/NO

Important Information: This SB will only be incorporated in your maintenance and operational documentation if this sheet is returned to Airbus and signed by a duly authorised representative. With the next feasible revision, this will result in

- Updating of maintenance documentation to show pre and post SB data.
- Updating of maintenance and operational documentation to show post SB data after embodiment.

If this SB requires previous or simultaneous accomplishment of other SBs, Airbus shall automatically include them in the manual revisions. Refer to SIL 00-037 for detailed information.

Please return this completed sheet to:

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Attn: SDC32 Technical Data and Documentation Services
FAX: (+33) 5 61 93 28 06
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Alternatively, SB lists via letters or fax are also accepted.

SERVICE BULLETIN
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Use this form to tell us what is your perception of the quality of this Service Bulletin. The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletins.
We thank you for the time you have taken in completing this form.

(Please rate on a scale of 1 to 4, with 4 being the highest score)

- Quality rating of this SB	4	3	2	1
- Quality rating of the Accomplishment Instructions	4	3	2	1
- Quality rating of the Illustrations	4	3	2	1
- Is this SB easy to understand ?	Y / N			

If you have had difficulties in the accomplishment of this SB please quote below the area(s) and give a short description of the issue.

	Planning		Material		Instructions
X	Effectivity	X	Kit content	X	Preparation
X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Industry support	X	Test
X	References	X	Re-identification	X	Close-Up
X	Publication	X	Tooling	X	Illustrations

Comments:

Operator: Date:

Name/Title:

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